



(12) **UK Patent** (19) **GB** (11) **2 418 690** (13) **B**

(45) Date of publication: **02.08.2006**

(54) Title of the invention: **System for radially expanding a tubular member**

(51) INT CL: **E21B 23/04** (2006.01) **E21B 23/08** (2006.01) **E21B 43/10** (2006.01)

(21) Application No: **0525663.1**

(22) Date of Filing: **12.05.2003**

Date Lodged: **16.12.2005**

(30) Priority Data:

(31) **60391703** (32) **26.06.2002** (33) **US**

(62) Divided from Application No

0501667.0 under Section 15(4) of the Patents Act 1977

(43) Date A Publication: **05.04.2006**

(72) Inventor(s):

David Paul Brisco

Lev Ring

(73) Proprietor(s):

Enventure Global Technology

(Incorporated in USA - Delaware)

**16200-A Park Row, Houston, Texas 77084,
United States of America**

(74) Agent and/or Address for Service:

Hasettine Lake & Co

Redcliff Quay, 120 Redcliff Street,

BRISTOL, BS1 6HU, United Kingdom

(52) UK CL (Edition X):

E1F FLA

(56) Documents Cited:

US 6575240 B1

US 6497289 B1

US 6470966 B2

US 6085838 A

US 20010047870 A

(58) Field of Search:

As for published application 2418690 A viz:

UK CL (Edition X) E1F

INT CL E21B

Other:

updated as appropriate

Additional Fields

UK CL (Edition X) E1F

INT CL E21B

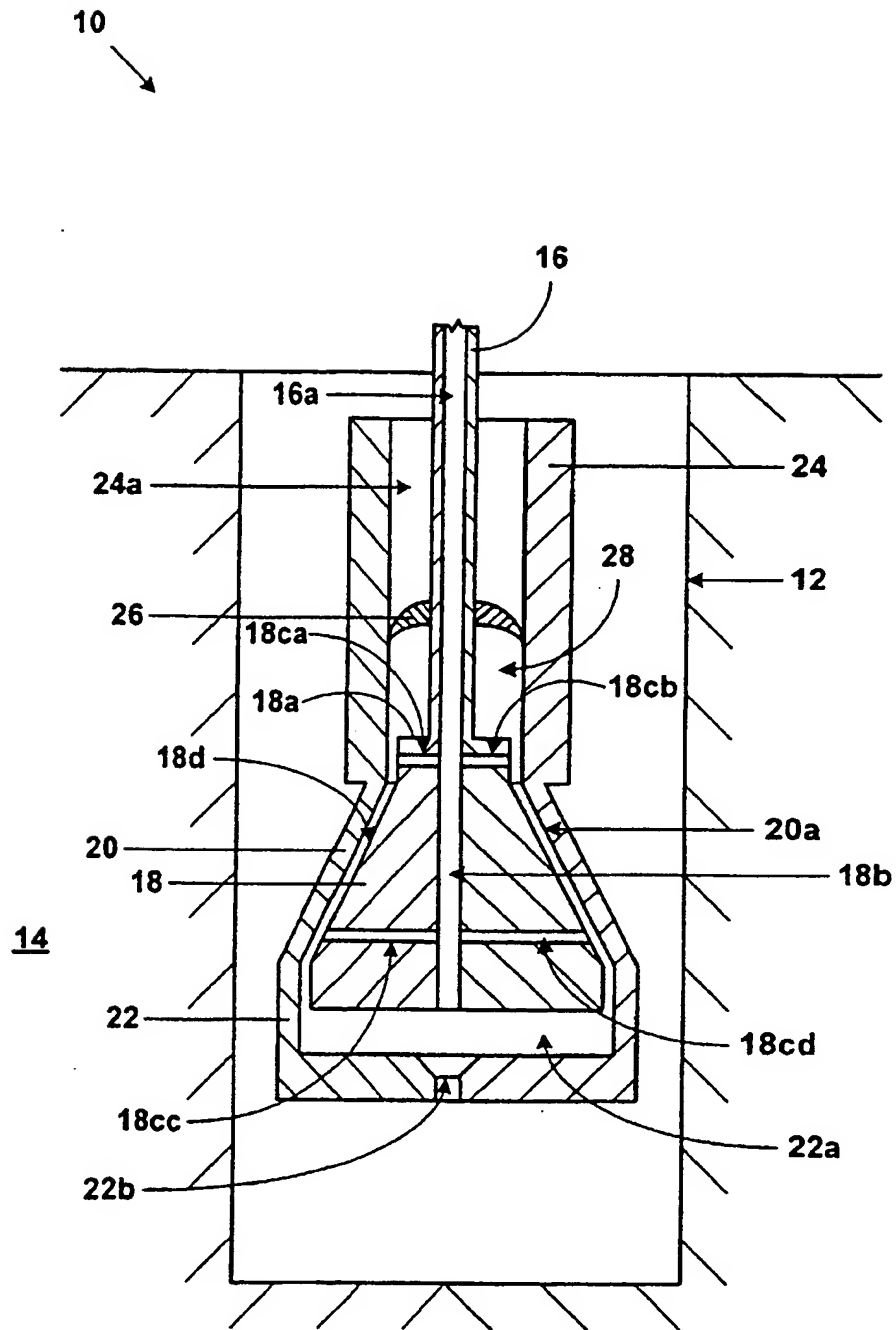


Fig. 1

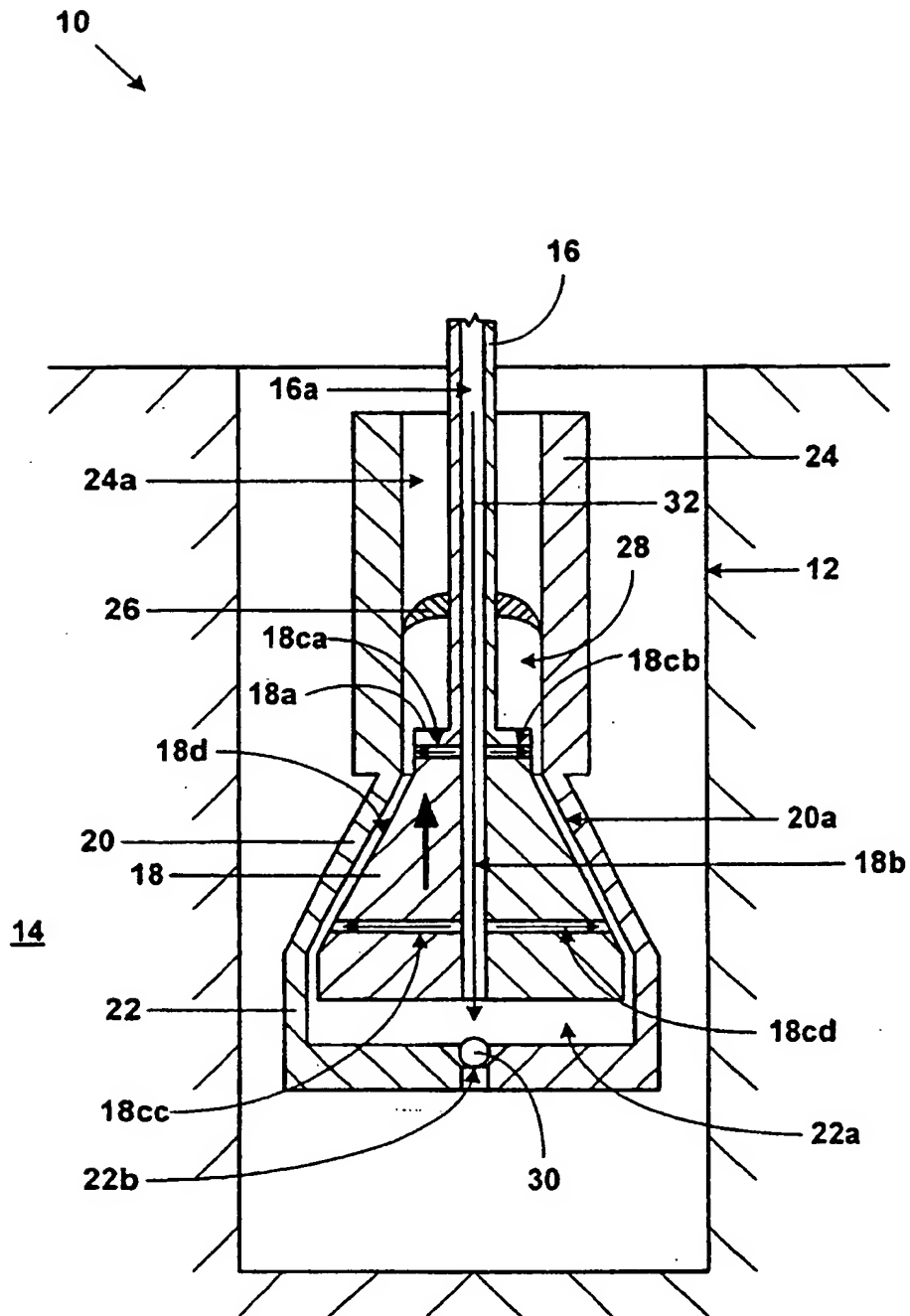


Fig. 2a

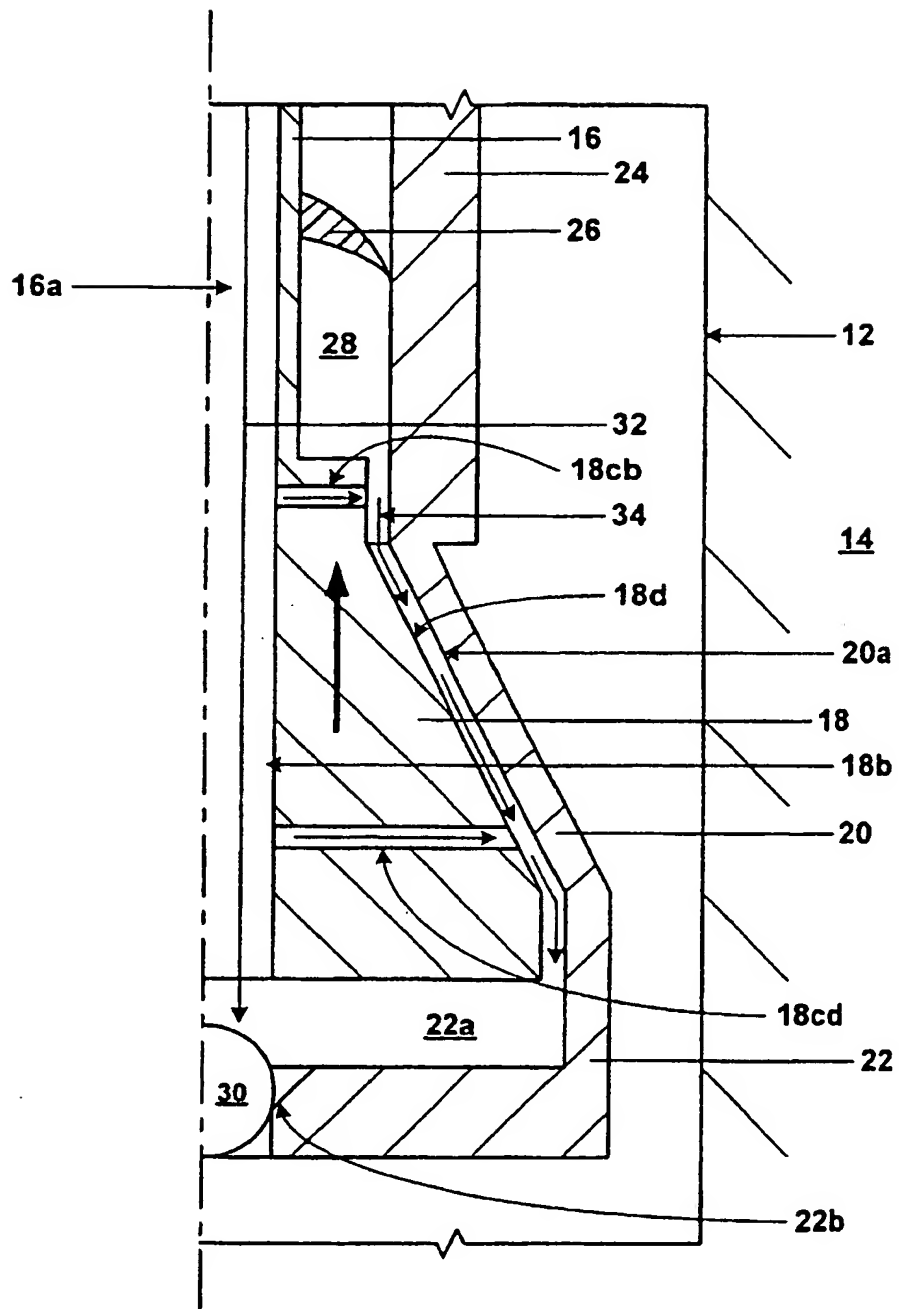
10
↘

Fig. 2b

TYPICAL
OPERATING
PRESSURE
FOR
RADIAL
EXPANSION
OF TUBULAR

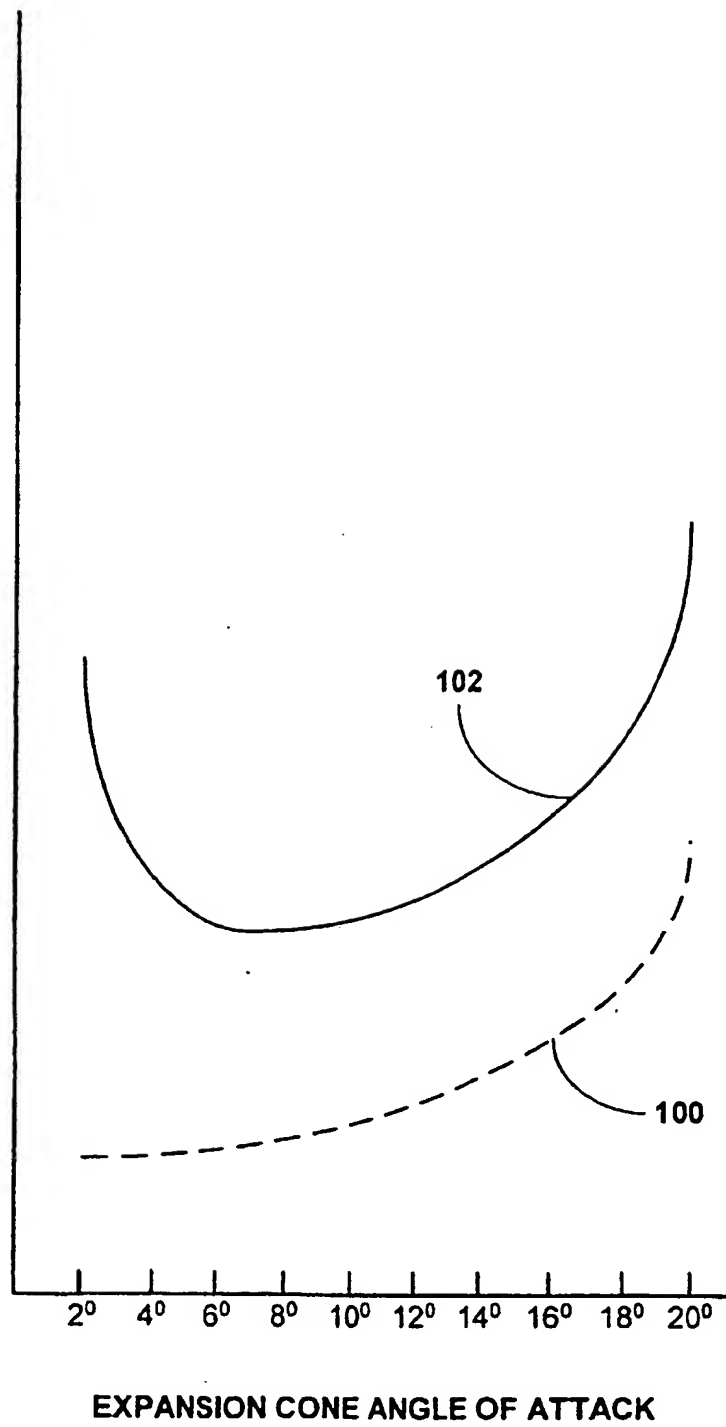


Fig. 3

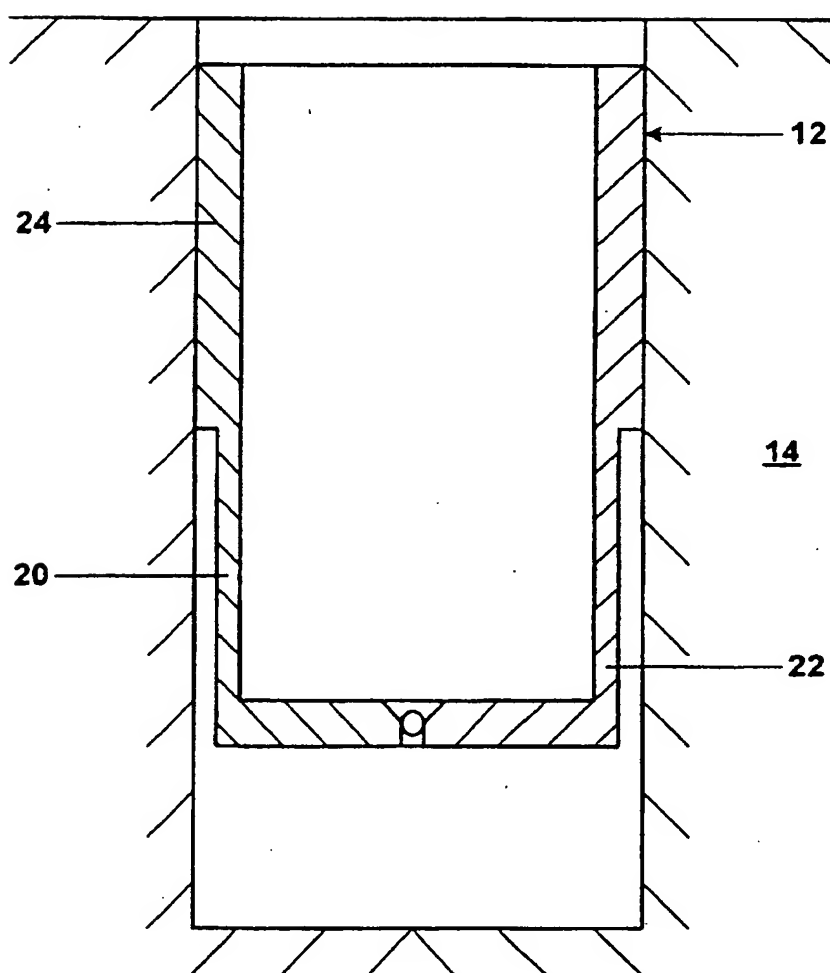


Fig. 4

SYSTEM FOR RADially EXPANDING A TUBULAR MEMBER**Cross Reference To Related Applications**

The present application claims the benefit of the filing dates of (1) U.S.
5 provisional patent application serial no. 60/391,703, attorney docket no 25791.90, filed
on 6/26/2002, the disclosure of which is incorporated herein by reference

The present application is related to the following: (1) U.S. patent application
serial no. 09/454,139, attorney docket no. 25791.03.02, filed on 12/3/1999, (2) U.S.
patent application serial no. 09/510,913, attorney docket no. 25791.7.02, filed on
10 2/23/2000, (3) U.S. patent application serial no. 09/502,350, attorney docket no.
25791.8.02, filed on 2/10/2000, (4) U.S. patent no. 6,328,113, (5) U.S. patent
application serial no. 09/523,460, attorney docket no. 25791.11.02, filed on 3/10/2000,
(6) U.S. patent application serial no. 09/512,895, attorney docket no. 25791.12.02, filed
on 2/24/2000, (7) U.S. patent application serial no. 09/511,941, attorney docket no.
15 25791.16.02, filed on 2/24/2000, (8) U.S. patent application serial no. 09/588,946,
attorney docket no. 25791.17.02, filed on 6/7/2000, (9) U.S. patent application serial
no. 09/559,122, attorney docket no. 25791.23.02, filed on 4/26/2000, (10) PCT patent
application serial no. PCT/US00/18635, attorney docket no. 25791.25.02, filed on
7/9/2000, (11) U.S. provisional patent application serial no. 60/162,671, attorney docket
20 no. 25791.27, filed on 11/1/1999, (12) U.S. provisional patent application serial no.
60/154,047, attorney docket no. 25791.29, filed on 9/16/1999, (13) U.S. provisional
patent application serial no. 60/159,082, attorney docket no. 25791.34, filed on
10/12/1999, (14) U.S. provisional patent application serial no. 60/159,039, attorney
docket no. 25791.36, filed on 10/12/1999, (15) U.S. provisional patent application serial
25 no. 60/159,033, attorney docket no. 25791.37, filed on 10/12/1999, (16) U.S.
provisional patent application serial no. 60/212,359, attorney docket no. 25791.38, filed
on 6/19/2000, (17) U.S. provisional patent application serial no. 60/165,228, attorney
docket no. 25791.39, filed on 11/12/1999, (18) U.S. provisional patent application serial
no. 60/221,443, attorney docket no. 25791.45, filed on 7/28/2000, (19) U.S. provisional
30 patent application serial no. 60/221,645, attorney docket no. 25791.46, filed on
7/28/2000, (20) U.S. provisional patent application serial no. 60/233,638, attorney
docket no. 25791.47, filed on 9/18/2000, (21) U.S. provisional patent application serial
no. 60/237,334, attorney docket no. 25791.48, filed on 10/2/2000, (22) U.S. provisional
patent application serial no. 60/270,007, attorney docket no. 25791.50, filed on

2/20/2001, (23) U.S. provisional patent application serial no. 60/262,434, attorney docket no. 25791.51, filed on 1/17/2001, (24) U.S. provisional patent application serial no. 60/259,486, attorney docket no. 25791.52, filed on 1/3/2001, (25) U.S. provisional patent application serial no. 60/303,740, attorney docket no. 25791.61, filed on 7/6/2001, (26) U.S. provisional patent application serial no. 60/313,453, attorney docket no. 25791.59, filed on 8/20/2001, (27) U.S. provisional patent application serial no. 60/317,985, attorney docket no. 25791.67, filed on 9/6/2001, (28) U.S. provisional patent application serial no. 60/3318,386, attorney docket no. 25791.67.02, filed on 9/10/2001, (29) U.S. utility patent application serial no. 09/969,922, attorney docket no. 25791.69, filed on 10/3/2001, (30) U.S. utility patent application serial no. 10/016,467, attorney docket no. 25791.70, filed on 12/10/2001, (31) U.S. provisional patent application serial no. 60/343,674, attorney docket no. 25791.68, filed on 12/27/2001, (32) U.S. provisional patent application serial no. 60/346,309, attorney docket no. 25791.92, filed on 1/7/2002, (33) U.S. provisional patent application serial no. 60/372,048, attorney docket no. 25791.93, filed on 4/12/2002, (34) U.S. provisional patent application serial no. 60/372,632, attorney docket no. 25791.101, filed on 4/15/2002, (35) U.S. provisional patent application serial no. 60/380,147, attorney docket no. 25791.104, filed on 5/6/2002, (36) U.S. provisional patent application serial no. 60/387,486, attorney docket no. 25791.107, filed on 6/10/2002, and (37) U.S. provisional patent application serial no. 60/387,961, attorney docket no. 25791.108, filed on 6/12/2002, the disclosures of which are incorporated herein by reference.

This invention relates generally to oil and gas exploration, and in particular to forming and repairing wellbore casings to facilitate oil and gas exploration and production.

25

Background of the Invention

Conventionally, when a wellbore is created, a number of casings are installed in the borehole to prevent collapse of the borehole wall and to prevent undesired outflow of drilling fluid into the formation or inflow of fluid from the formation into the borehole. The borehole is drilled in intervals whereby a casing which is to be installed in a lower borehole interval is lowered through a previously installed casing of an upper borehole interval. As a consequence of this procedure the casing of the lower interval is of smaller diameter than the casing of the upper interval. Thus, the casings are in a nested arrangement with casing diameters decreasing in downward direction. Cement annuli are provided between the outer surfaces of the casings and the borehole wall to

seal the casings from the borehole wall. As a consequence of this nested arrangement a relatively large borehole diameter is required at the upper part of the wellbore. Such a large borehole diameter involves increased costs due to heavy casing handling equipment, large drill bits and increased volumes of drilling fluid and drill cuttings.

- 5 Moreover, increased drilling rig time is involved due to required cement pumping, cement hardening, required equipment changes due to large variations in hole diameters drilled in the course of the well, and the large volume of cuttings drilled and removed.

10 The present invention is directed to overcoming one or more of the limitations of the existing processes for forming and repairing wellbore casings.

Summary of the Invention

According to the present invention there is provided an apparatus for radially expanding and plastically deforming a tubular member, comprising:

- a tubular support member that defines a longitudinal passage;
- 15 an expansion device coupled to an end of the tubular support member that defines a longitudinal passage and one or more radial passages that extend from the longitudinal passage and extend to an outer surface of the expansion device;
- a tubular expansion launcher that receives the expansion device;
- an expandable tubular member coupled to an end of the tubular expansion
- 20 launcher; and
- one or more cup seals coupled to the tubular support member for sealingly engaging the interior surface of the expandable tubular member.

- Preferably, the expansion device comprises a tapered outer surface and a non tapered outer surface; and
- 25 wherein at least one of the radial passages extends to the non tapered outer surface.

Preferably, at least one other of the radial passages extends to the tapered outer surface.

- Preferably, the expansion device comprises a tapered outer surface and a non tapered outer surface;
- 30

wherein at least one of the radial passages extends to the non tapered outer surface; and

wherein at least one other of the radial passages extends to the tapered outer surface.

Preferably, the expansion device comprises a tubular expansion cone;
wherein the tubular expansion launcher comprises a tubular expansion cone
launcher that receives the tubular expansion cone; and

5 wherein the apparatus further comprises a tubular shoe coupled to an end of the
tubular expansion cone launcher that defines a valveable longitudinal passage.

Preferably, the tubular expansion cone comprises a tapered outer surface and a
non tapered outer surface; and

10 wherein at least one of the radial passages extends to the non tapered outer
surface.

Preferably, at least one other of the radial passages extends to the tapered outer
surface.

Preferably, the tubular expansion cone comprises a tapered outer surface and a
non tapered outer surface;

15 wherein at least one of the radial passages extends to the non tapered outer
surface; and

wherein at least one other of the radial passages extends to the tapered outer
surface.

Brief Description of the Drawings

Fig. 1 is a fragmentary cross-sectional illustration of the placement of an apparatus for radially expanding a tubular member within a borehole that traverses a subterranean formation.

5 Figs. 2a and 2b are fragmentary cross-sectional illustrations of the apparatus of Fig. 1 after initiating the radial expansion and plastic deforming of the tubular member.

Fig. 3 is a graphical illustration of the unexpected result provided during the operation of the apparatus of Figs. 2a and 2b during the radial expansion and plastic deformation of the tubular member.

10 Fig. 4 is a fragmentary cross-sectional illustration of the apparatus of Figs. 2a and 2b after completing the radial expansion and plastic deformation of the tubular member.

Detailed Description of the Illustrative Embodiments

In an exemplary embodiment, as illustrated in Fig. 1, an apparatus 10 is positioned within a borehole 12 that traverses a subterranean formation 14 that may include a source of hydrocarbons and/or geothermal energy.

15 In an exemplary embodiment, the apparatus includes a tubular support member 16 that defines a longitudinal passage 16a. An upper end 18a of a tubular expansion cone 18 that defines a longitudinal passage 18b, radial passages, 18ca and 18cb, that extend from the longitudinal passage to the outer surface of the tubular expansion cone above a conical outer surface 18d, and radial passages, 18cc and 18cd, that extend from the longitudinal passage to the conical outer surface, is coupled to an end of the tubular support member 16. In this manner, fluidic materials may be conveyed from the passage 16a of the tubular support member 16 through the longitudinal passage 18b of the tubular expansion cone 18 and into the radial passages, 18ca, 18cb, 18cc, and 18cd, of the tubular expansion cone.

20 A tubular tapered expansion cone launcher 20 receives the outer conical surface 18d of the tubular expansion cone 18 within an interior passage 20a. In an exemplary embodiment, the interior surface of the tubular tapered expansion cone launcher 20 is a conical surface that is complementary shaped with respect to the outer conical surface 18d of the tubular expansion cone 18. An end of a tubular shoe 22 is coupled to an end of the tubular tapered expansion cone launcher 20 that defines an interior passage 22a and a valveable longitudinal passage 22b that may be adapted to receive a valve member such as, for example, a ball.

An end of an expandable tubular 24 that defines an internal passage 24a is coupled to another end of the tubular tapered expansion cone launcher 20. In an exemplary embodiment, the wall thickness of the expandable tubular 24 is greater than the wall thickness of the tubular tapered expansion cone launcher 20. In this manner,
5 the initiation of the radial expansion of the expandable tubular member 24 is facilitated and the apparatus 10 may be positioned within wellbores 12 having tight radial clearances relative to the expansion cone launcher 20.

A resilient GuibersonJ sealing cup 26 is coupled to the exterior of the tubular support 16. In an exemplary embodiment, during operation of the apparatus 10, the
10 sealing cup 26 engages the interior surface of the expandable tubular member 24 and thereby defines an annular chamber 28 between the exterior of the tubular support 16 and the interior of the expandable tubular member above the tubular expansion cone 18.

In an exemplary embodiment, as illustrated in Figs. 2a and 2b, during operation
15 of the apparatus 10, a ball 30 is placed in the valveable passage 22b of the shoe 22 by injecting a fluidic material 32 into the apparatus 10 through the passages 16a and 18b. In this manner, the interior 22a of the tubular shoe 22 below the tubular expansion cone 18 and the annular chamber 28 above the tubular expansion cone below the GuibersonJ cup seal 26 may both be pressurized. In particular, continued injection of
20 the fluidic material 32 into the apparatus 10 through the passages 16a and 18b will pressurize the interior of the tubular shoe 22 below the tubular expansion cone 18 as well as the annular chamber 28 above the tubular expansion cone below the GuibersonJ cup seal 26. As a result, the tubular expansion cone 18 will be displaced upwardly in the longitudinal direction relative to the tubular expansion cone launcher
25 20, the tubular shoe 22, and the expandable tubular member 24. In particular, the pressurization of the annular chamber 28 will cause the GuibersonJ cup seal 26 to pull the tubular expansion cone 18 upwardly out of the apparatus 10. Furthermore, the pressurization of the interior 22a of the tubular shoe 22 below the tubular expansion cone 18 will push the tubular expansion cone upwardly out of the apparatus 10. As a
30 result, the tubular expansion cone launcher 20 and the expandable tubular member 24 are radially expanded and plastically deformed.

In an exemplary embodiment, during the radial expansion and plastic deformation of the tubular expansion cone launcher 20 and the expandable tubular member 24, the fluidic material 32 is conveyed through the radial passages, 18ca,

18cb, 18cc, and 18cd, into the annulus 34 defined between the conical exterior surface 18d of the tubular expansion cone 18 and the interior surfaces of the tubular expansion cone launcher 20 and/or the expandable tubular member 24. As an unexpected result, the tubular expansion cone launcher 20 and/or the expandable tubular member 24

5 hydroplane on the conical outer surface 18d of the tubular expansion cone 18 during the radial expansion and plastic deformation of the tubular expansion cone launcher and expandable tubular member. During exemplary experimental testing of the apparatus 10, the unexpected hydroplaning of the expansion cone launcher 20 and/or the expandable tubular member 24 hydroplane on the conical outer surface 18d of the

10 tubular expansion cone 18 during the radial expansion and plastic deformation of the tubular expansion cone launcher and expandable tubular member provided the further unexpected result of reducing the operating pressure of the fluidic material 32 required to radially expand and plastically deform the tubular expansion cone launcher 20 and/or the expandable tubular member 24. In an exemplary experimental test of the

15 apparatus 10, the operating pressure within the annulus 34 was approximately equal to the operating pressures within the apparatus 10 below the tubular expansion cone 18 and within the annular chamber 28.

As illustrated in Fig. 3, the curve 100 illustrates typical required operating pressures of the fluidic material 32 in order to radially expand and plastically deform the

20 tubular expansion cone launcher 20 and/or the expandable tubular member 24 for a range of angles of attack of the conical outer surface 18d of the tubular expansion cone 18. As will be recognized by persons having ordinary skill in the art, the angle of the attack of the conical outer surface 18d of the tubular expansion cone 18 refers to the angle of inclination of the conical outer surface relative to the longitudinal direction. By

25 contrast, the curve 102 illustrates typical required operating pressures of the fluidic material 32 in order to radially expand and plastically deform the expandable tubular member 24 for a range of angles of attack of the conical outer surface 18d of the tubular expansion cone 18 where the radial passages, 18ca, 18cb, 18cc, and 18cd, were omitted from the tubular expansion cone. Unexpectedly, the omission of the

30 radial passages, 18ca, 18cb, 18cc, and 18cd, from the tubular expansion cone 18 of the apparatus 10 significantly increased the required operating pressures of the fluidic material 32 in order to radially expand and plastically deform the expandable tubular member 24 across the range of angles of attack of the conical outer surface 18d of the tubular expansion cone 18. Thus, the unexpected hydroplaning of the expansion cone

launcher 20 and the expandable tubular member 24 hydroplane on the conical outer surface 18d of the tubular expansion cone 18 during the radial expansion and plastic deformation of the tubular expansion cone launcher and expandable tubular member provided the further unexpected result of reducing the operating pressure of the fluidic material 32 required to radially expand and plastically deform the tubular expansion cone launcher and/or the expandable tubular member.

In an exemplary embodiment, as illustrated in Fig. 4, after completing the radial expansion and plastic deformation of the tubular expansion cone launcher 20 and the expandable tubular member 24, the expandable tubular member is coupled to the interior surface of the borehole 12.

It is understood that variations may be made in the foregoing without departing from the scope of the invention. For example, the teachings of the present illustrative embodiments may be used to provide a wellbore casing, a pipeline, or a structural support. Furthermore, the elements and teachings of the various illustrative embodiments may be combined in whole or in part in some or all of the illustrative embodiments. In addition, the tubular expansion cone 18 may include one or more radial passages 18c extending from the longitudinal passage 18b to the exterior surface of the tubular expansion cone. Furthermore, the apparatus may include one or more GuibersonJ cup seals 26.

Although illustrative embodiments of the invention have been shown and described, a wide range of modification, changes and substitution is contemplated in the foregoing disclosure. Accordingly, it is appropriate that the appended claims be construed broadly.

CLAIMS

1. An apparatus for radially expanding and plastically deforming a tubular member, comprising:
 - 5 a tubular support member that defines a longitudinal passage;
an expansion device coupled to an end of the tubular support member that defines a longitudinal passage and one or more radial passages that extend from the longitudinal passage and extend to an outer surface of the expansion device;
a tubular expansion launcher that receives the expansion device;
 - 10 an expandable tubular member coupled to an end of the tubular expansion launcher; and
one or more cup seals coupled to the tubular support member for sealingly engaging the interior surface of the expandable tubular member.
- 15 2. The apparatus of claim 1, wherein the expansion device comprises a tapered outer surface and a non tapered outer surface; and
wherein at least one of the radial passages extends to the non tapered outer surface.
- 20 3. The apparatus of claim 2, wherein at least one other of the radial passages extends to the tapered outer surface.
4. The apparatus of claim 1, wherein the expansion device comprises a tapered outer surface and a non tapered outer surface;
 - 25 wherein at least one of the radial passages extends to the non tapered outer surface; and
wherein at least one other of the radial passages extends to the tapered outer surface.
- 30 5. The apparatus of claim 1 wherein the expansion device comprises a tubular expansion cone;
wherein the tubular expansion launcher comprises a tubular expansion cone launcher that receives the tubular expansion cone; and

wherein the apparatus further comprises a tubular shoe coupled to an end of the tubular expansion cone launcher that defines a valveable longitudinal passage.

6. The apparatus of claim 5, wherein the tubular expansion cone comprises a tapered outer surface and a non tapered outer surface; and
5 wherein at least one of the radial passages extends to the non tapered outer surface.

7. The apparatus of claim 6, wherein at least one other of the radial passages
10 extends to the tapered outer surface.

8. The apparatus of claim 5, wherein the tubular expansion cone comprises a tapered outer surface and a non tapered outer surface;
wherein at least one of the radial passages extends to the non tapered outer
15 surface; and
wherein at least one other of the radial passages extends to the tapered outer surface.

(12) UK Patent Application (19) GB (11) 2 418 941 (13) A

(43) Date of A Publication 12.04.2006

(21) Application No: 0525768.8
(22) Date of Filing: 05.05.2003
Date Lodged: 19.12.2005
(30) Priority Data:
(31) 60387486 (32) 10.06.2002 (33) US
(62) Divided from Application No
0500184.7 under Section 15(4) of the Patents Act 1977

(51) INT CL:
E21B 43/10 (2006.01) E21B 19/16 (2006.01)
(52) UK CL (Edition X):
E1F FLA
(56) Documents Cited:
GB 2408278 A
(58) Field of Search:
UK CL (Edition X) E1F
INT CL E21B
Other: Online: EPODOC, WPI

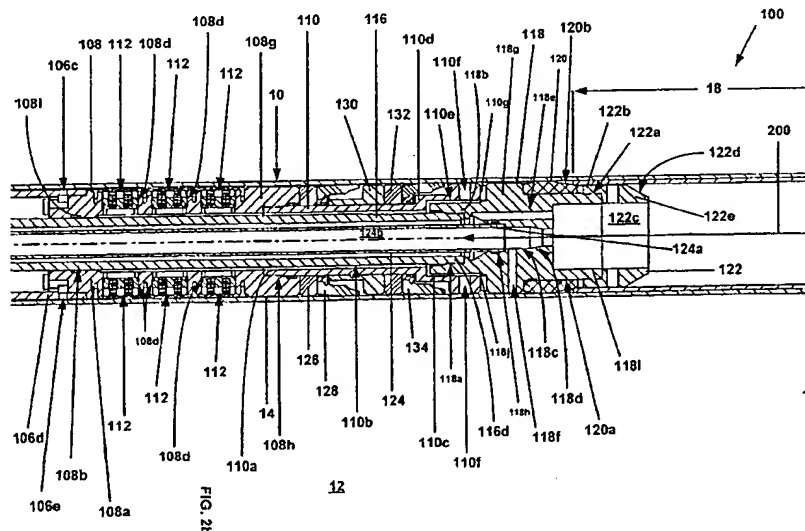
(71) Applicant(s):
Enventure Global Technology
(Incorporated in USA - Delaware)
16200-A Park Row, Houston, Texas 77084,
United States of America

(72) Inventor(s):
David Paul Brisco

(continued on next page)

(54) Abstract Title: **Tubular expander**

(57) An apparatus for radially expanding and plastically deforming a tubular member 10, comprising: a tubular support member defining a longitudinal passage; a tubular outer sleeve coupled to the tubular support member defining a longitudinal passage and a plurality of radial bypass ports; an hydraulic slip 112 coupled to the tubular outer sleeve for controllably engaging the tubular member; one or more packer cups 134 coupled to the tubular outer sleeve for sealingly engaging the tubular member 10; a tubular inner sleeve 116 positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage, an annular longitudinal bypass passage, and one or more radial bypass passages; and a tubular expansion cone 122 having a throat passage for receiving a ball, an L-shaped bypass port, and a radial pressure port including an tapered outer expansion surface 122d for radially expanding and plastically deforming the tubular member 10.



GB 2418941 A continuation

(74) Agent and/or Address for Service:
Haseltine Lake & Co
Redcliff Quay, 120 Redcliff Street,
BRISTOL, BS1 6HU, United Kingdom

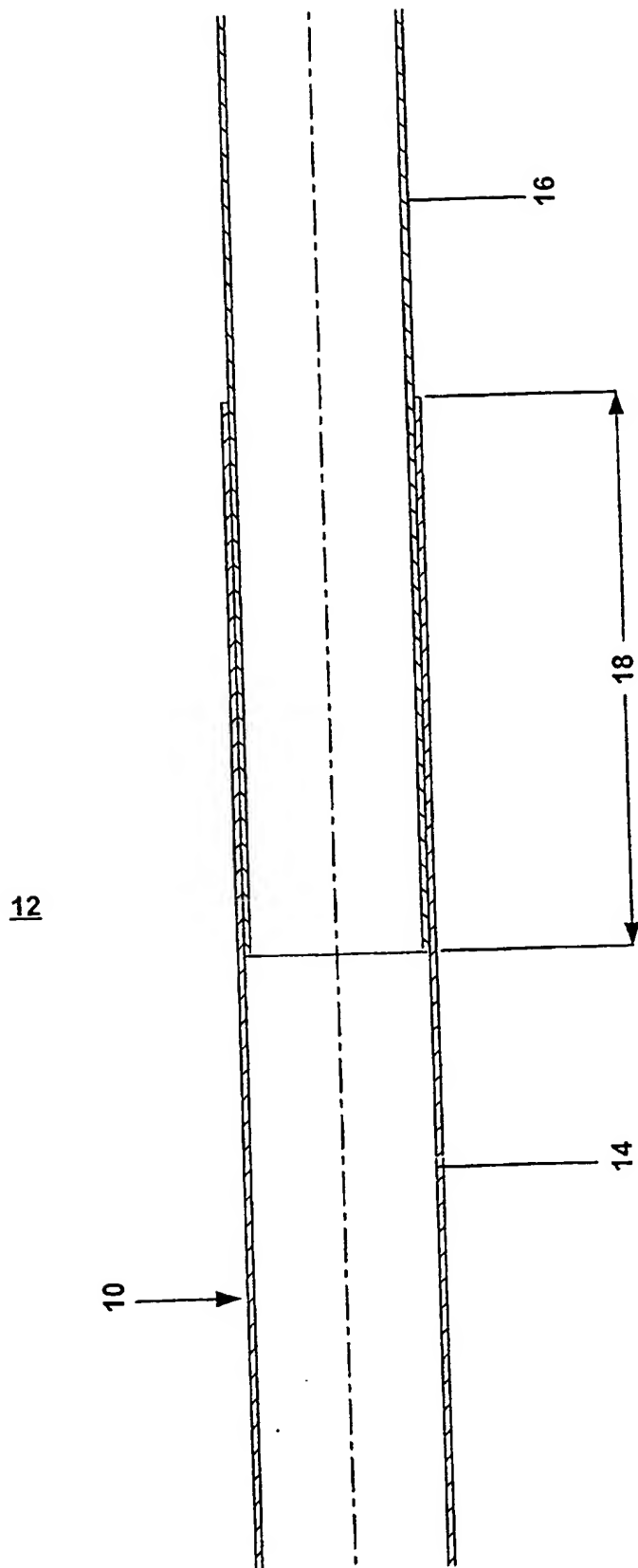


FIG. 1

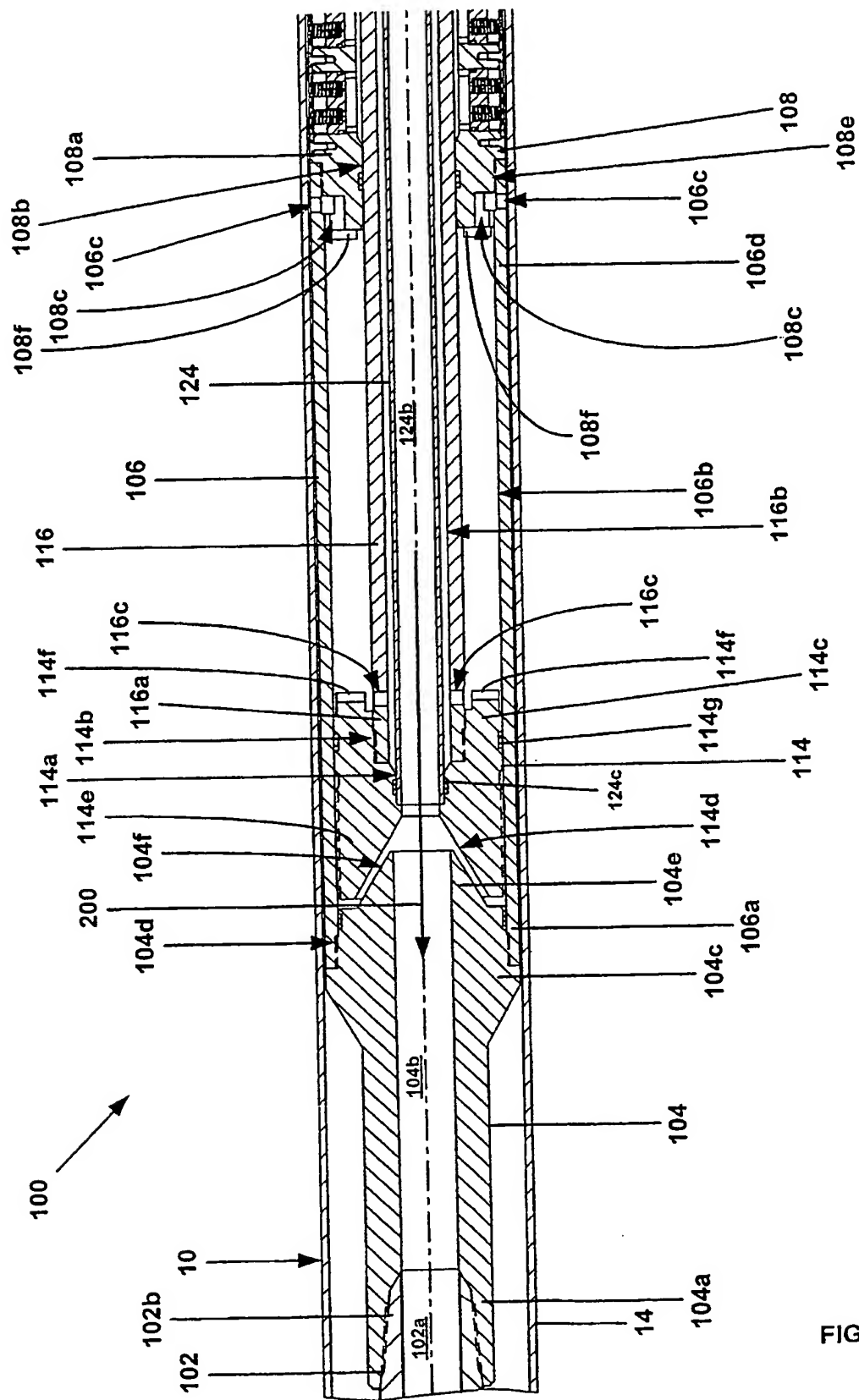
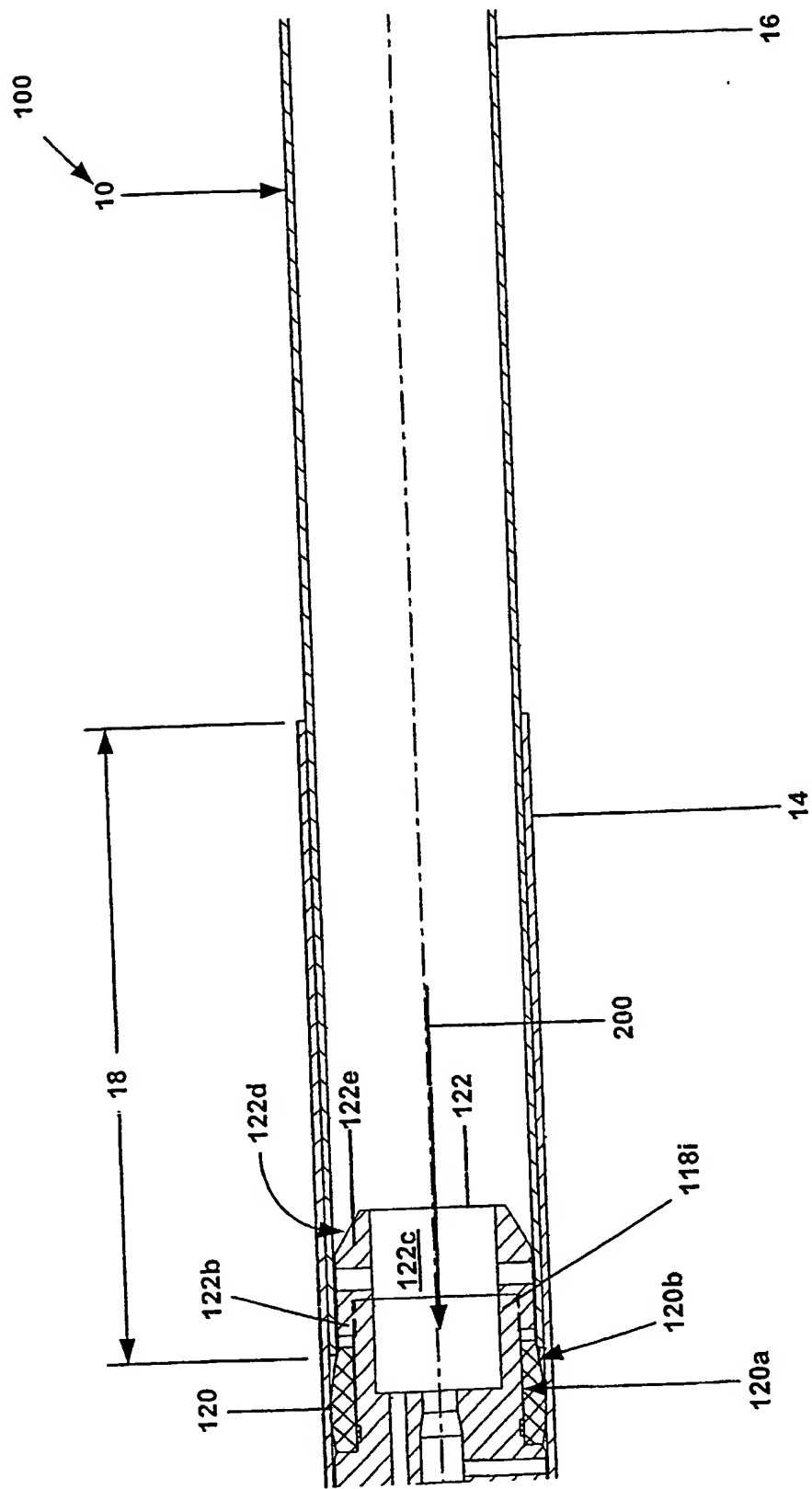


FIG. 2a

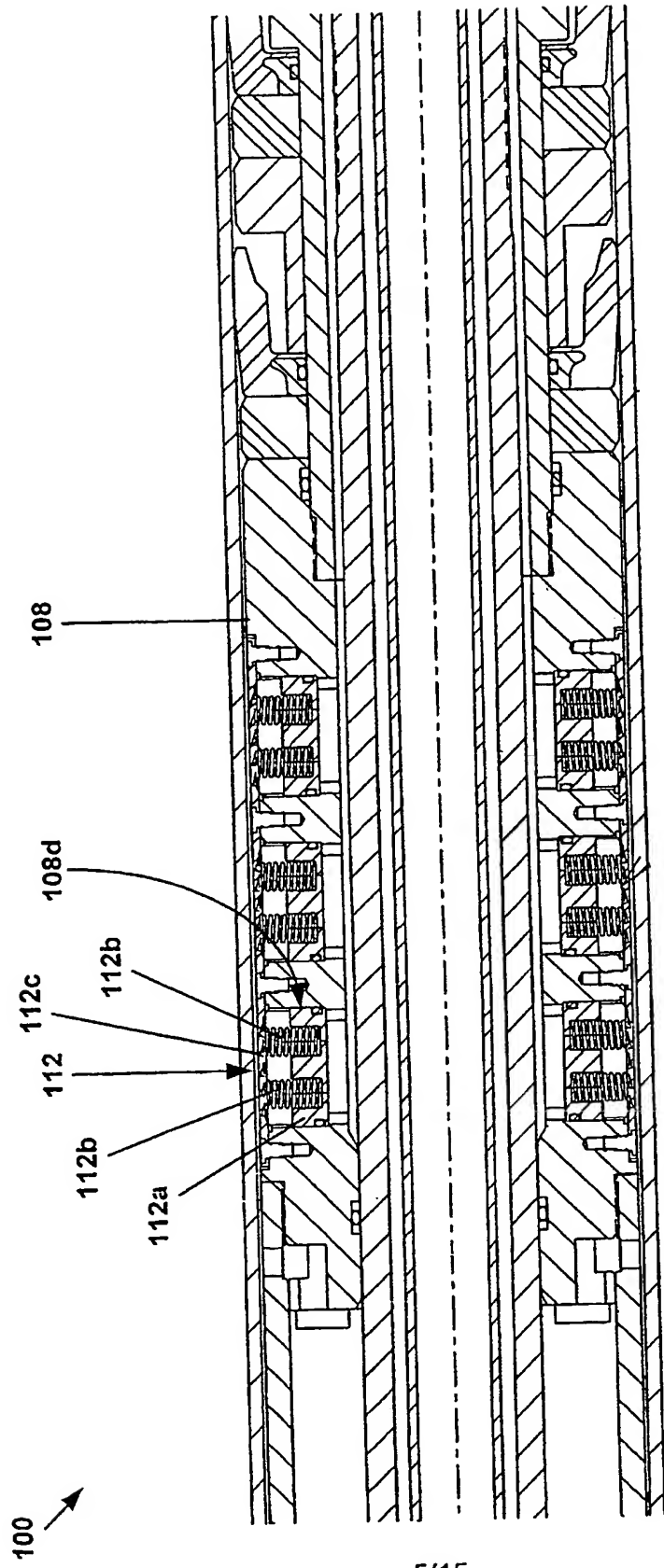


3/15



12

FIG. 2c



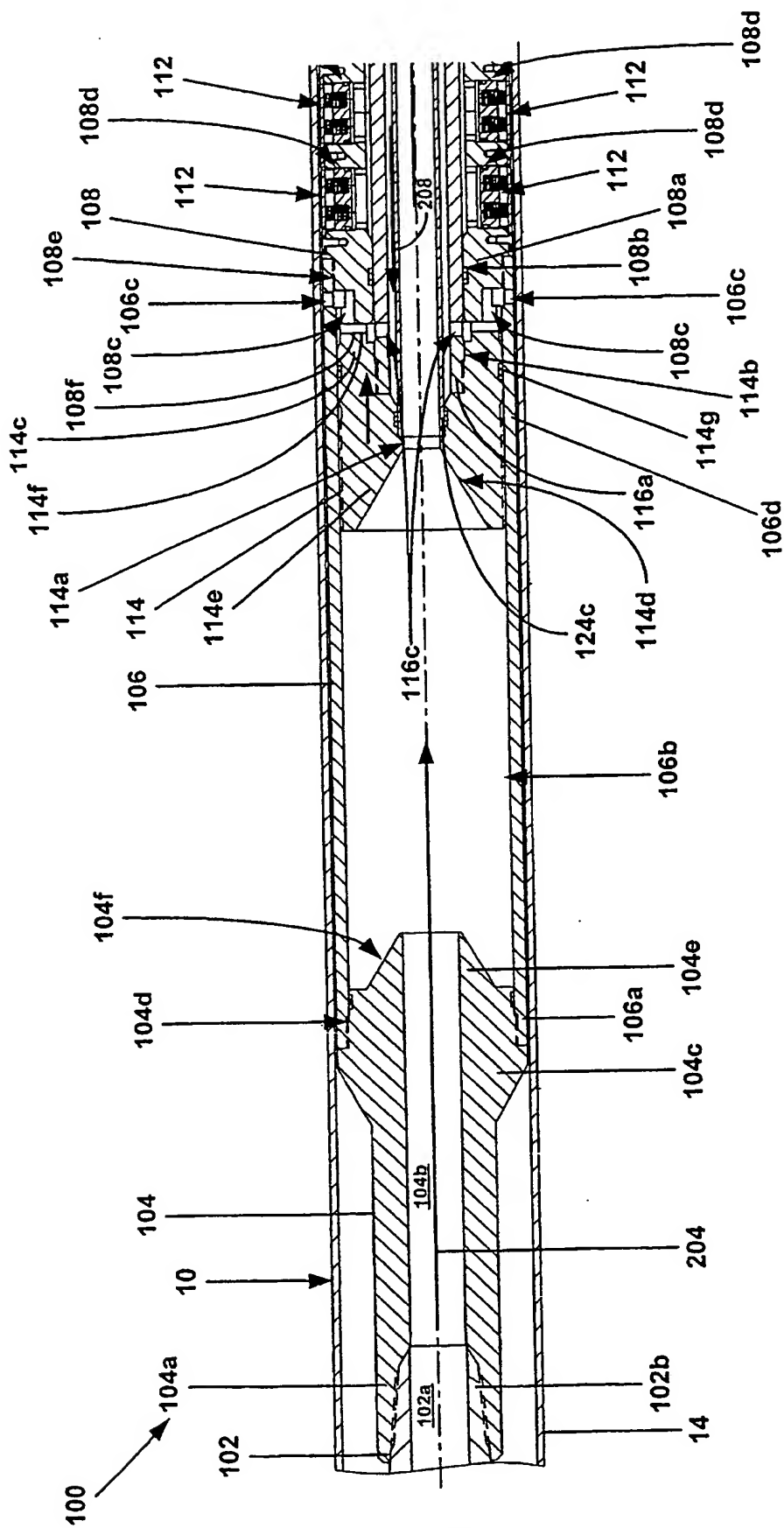


FIG. 3a

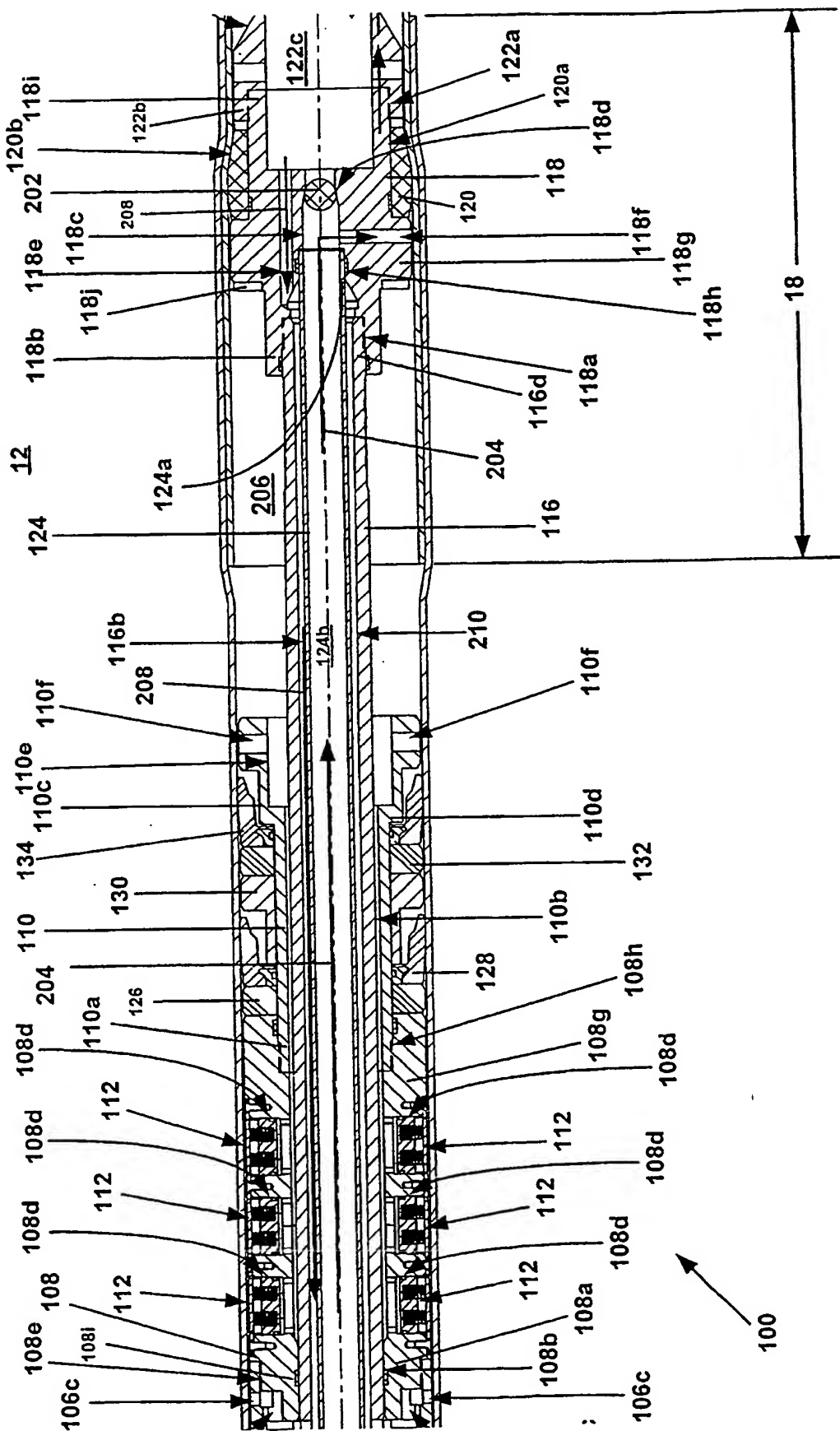


FIG. 3b

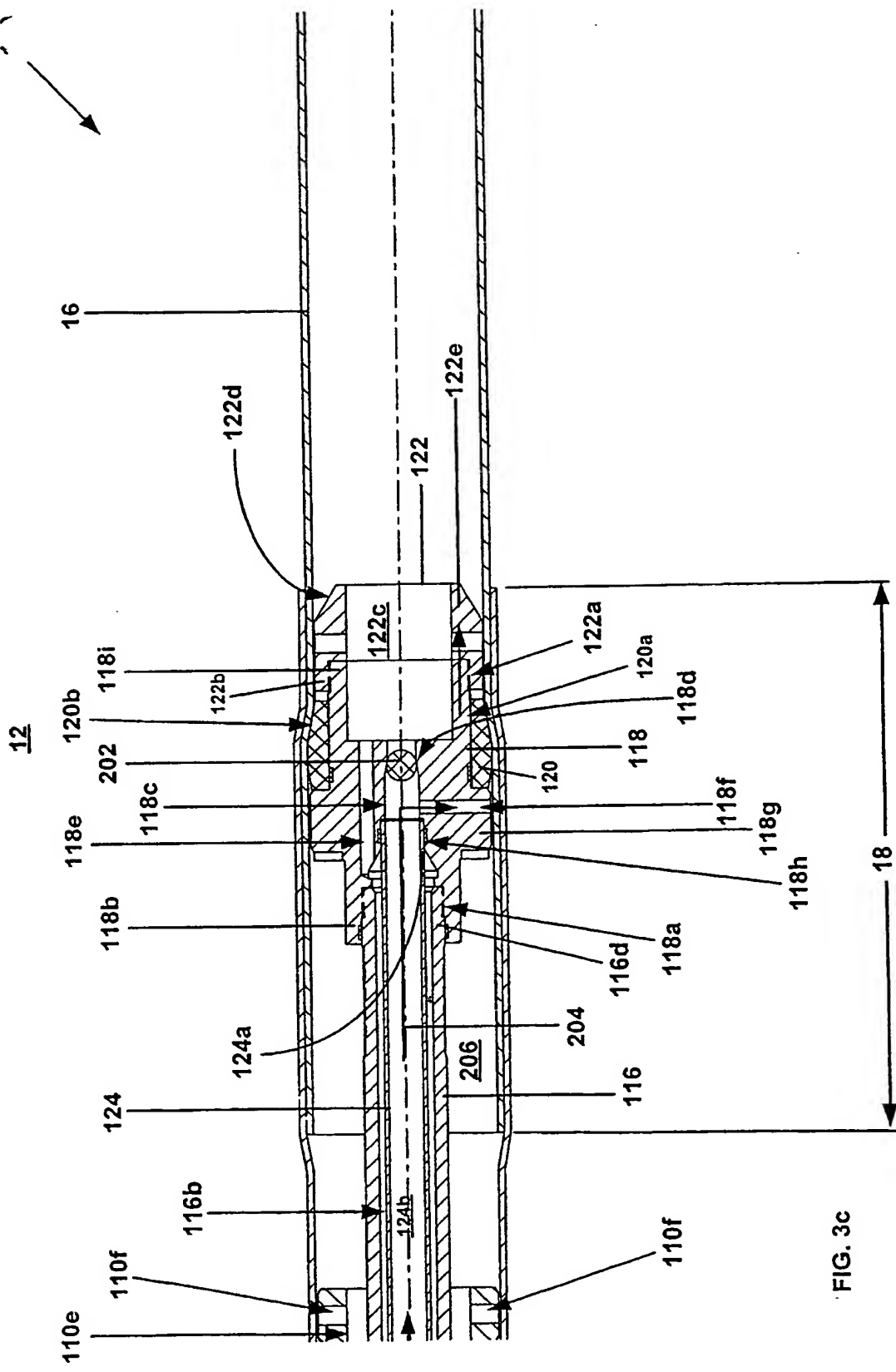


FIG. 3c

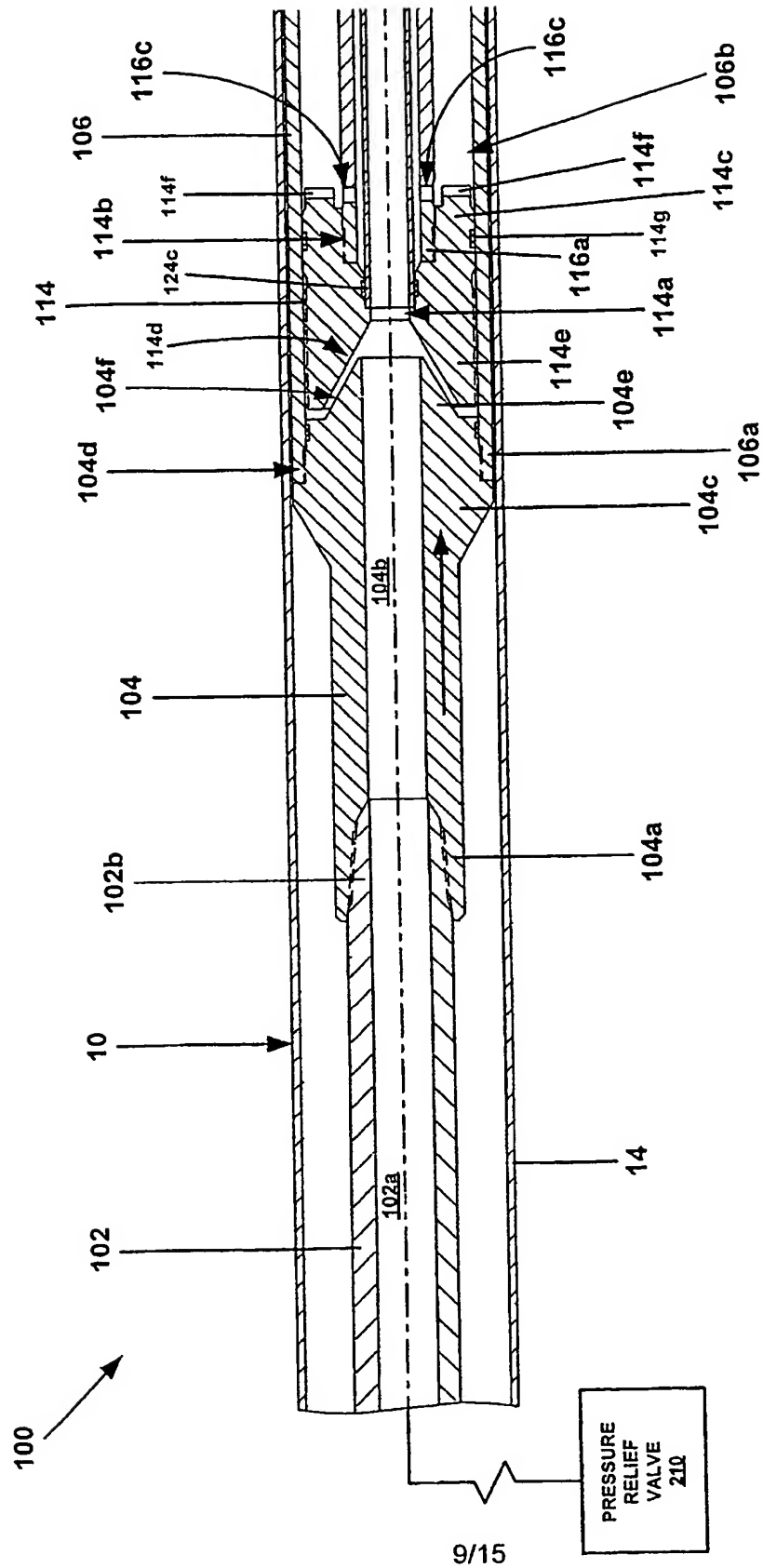


FIG. 4a

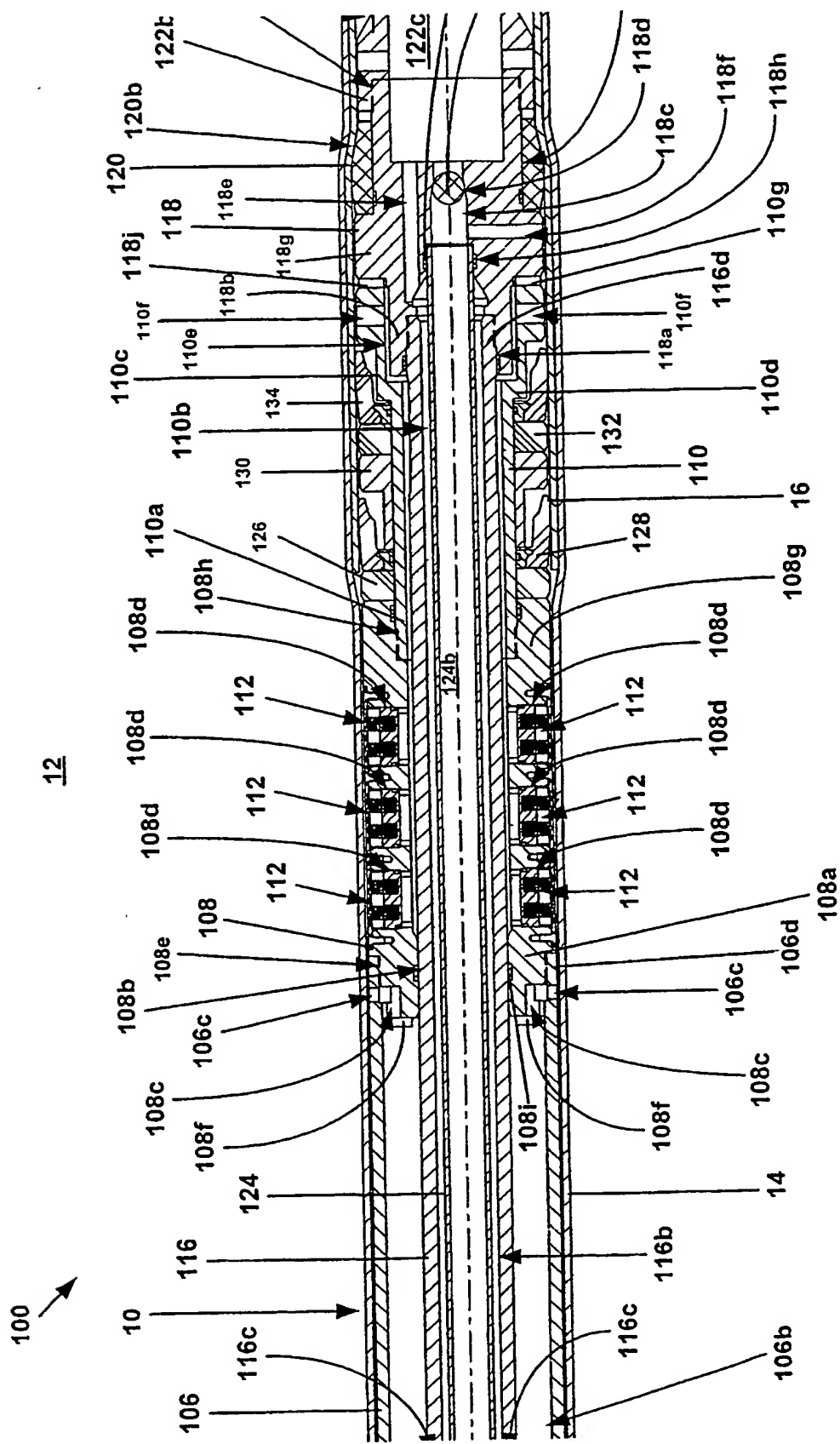


Fig. 4b

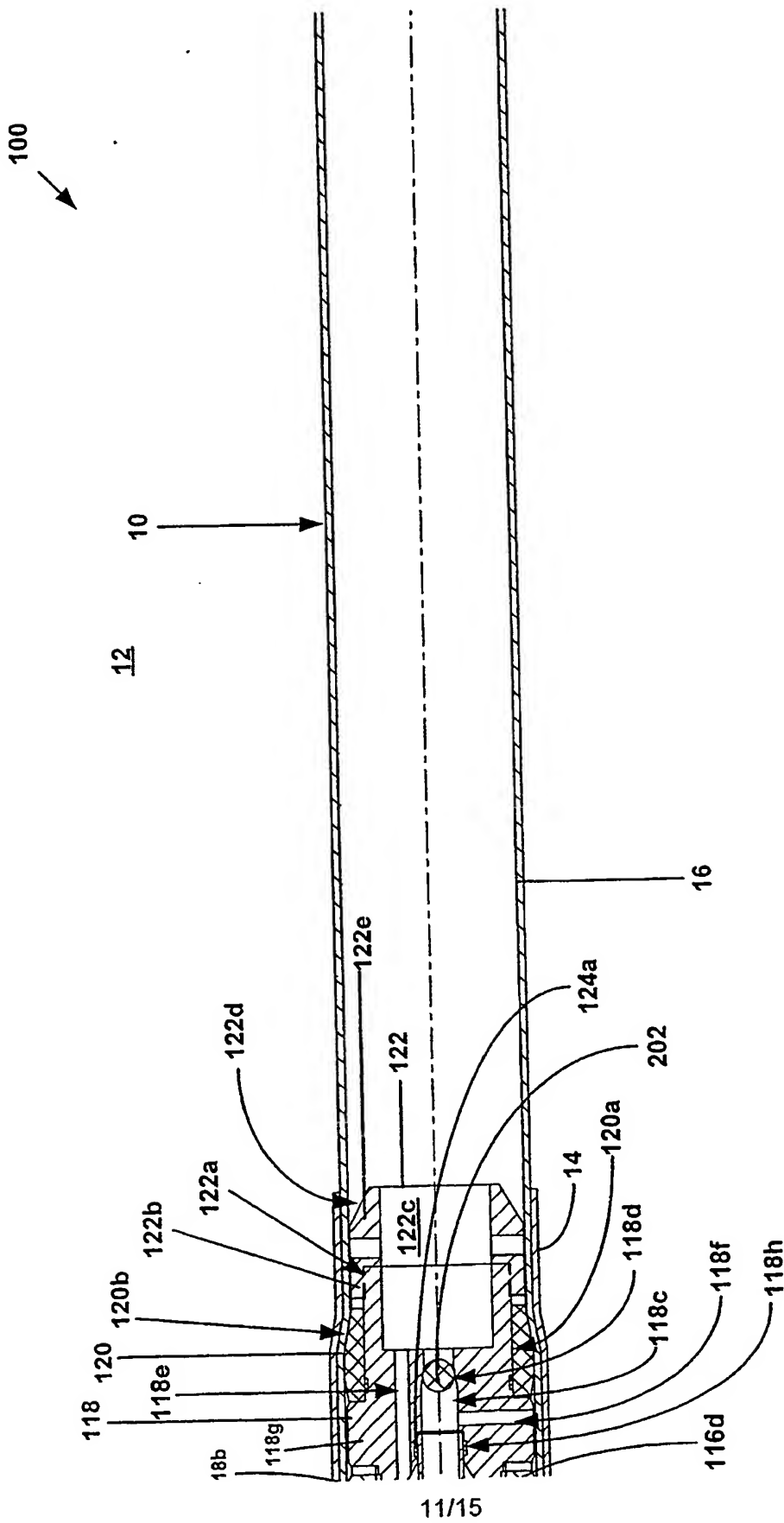


Fig. 4c

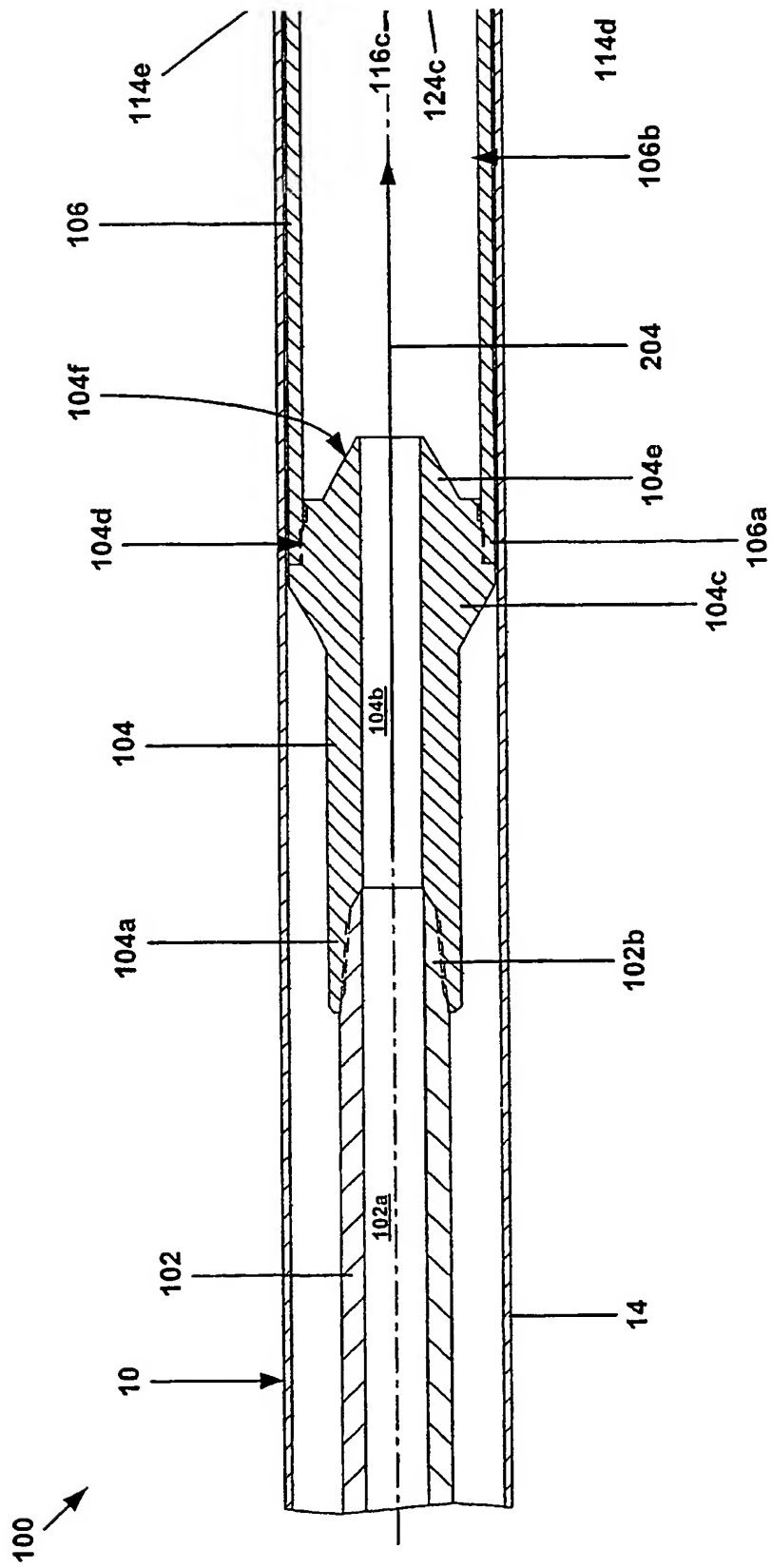


FIG. 5a

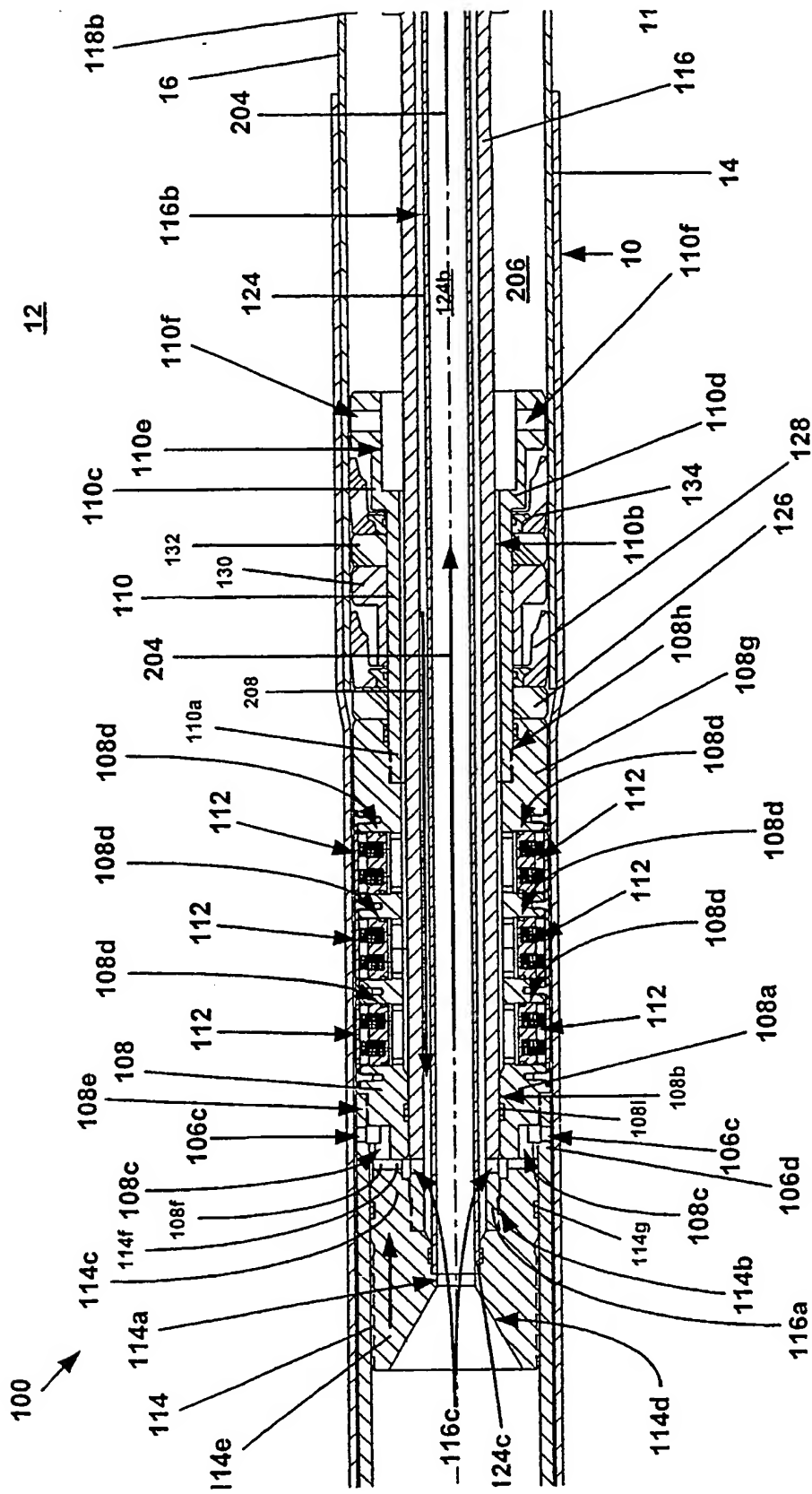


Fig. 5b

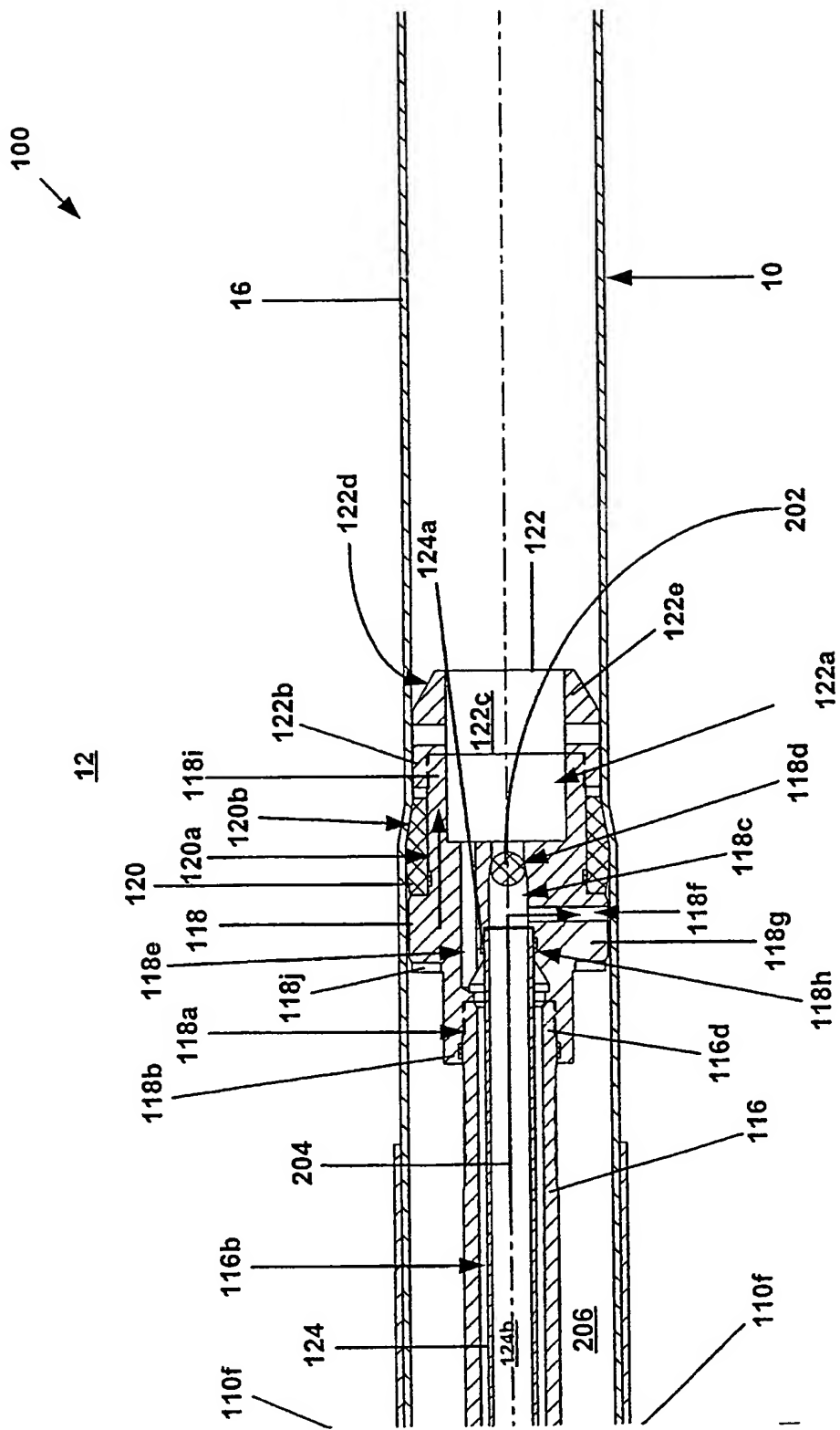
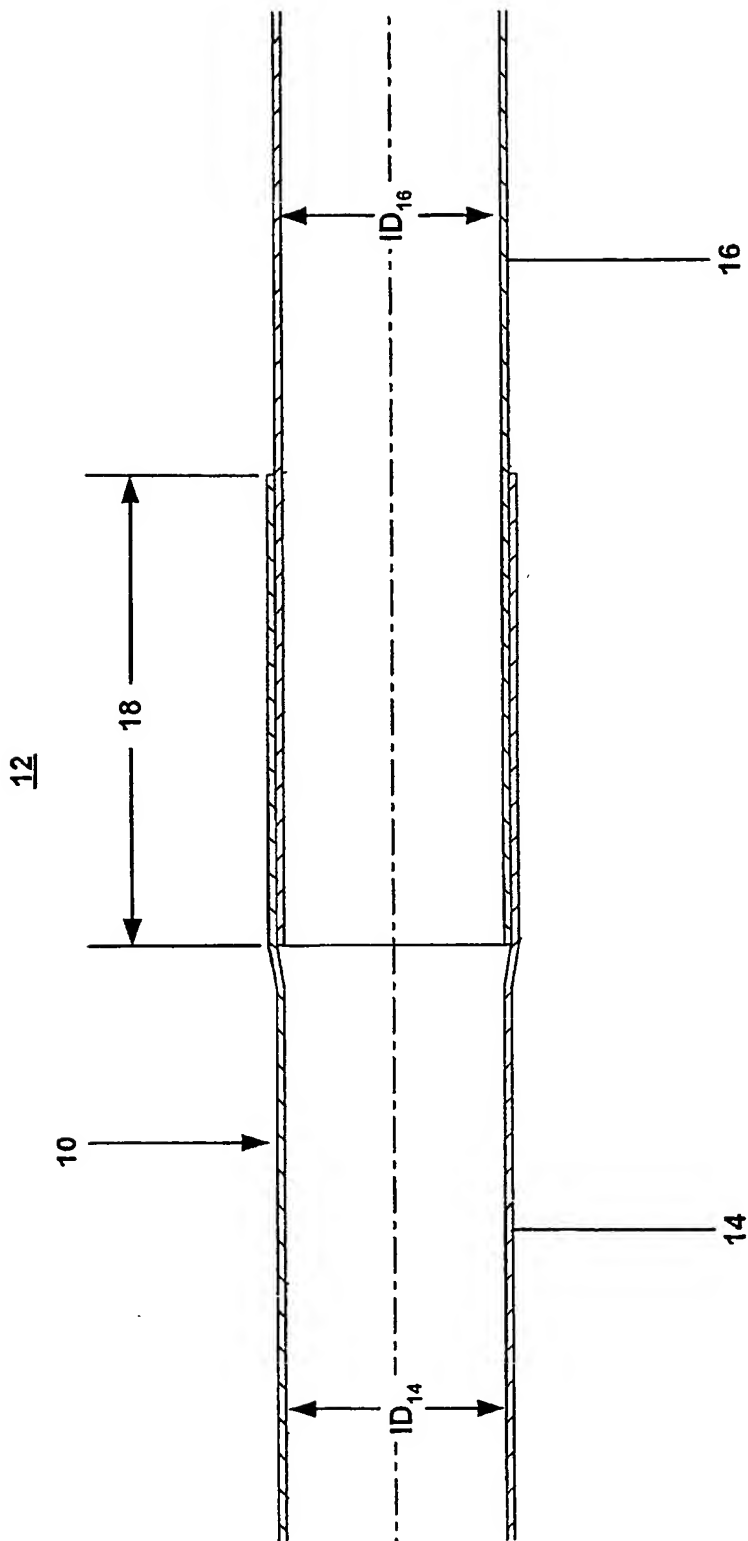


Fig. 5c



15/15

FIG. 6

MONO DIAMETER WELLBORE CASING**Cross Reference To Related Applications**

5 The present application claims the benefit of the filing dates of (1) U.S. provisional patent application serial no. 60/387,486, attorney docket no 25791.107, filed on 6/10/2002, the disclosure of which is incorporated herein by reference.

The present application is related to the following: (1) U.S. patent application serial no. 09/454,139, attorney docket no. 25791.03.02, filed on 12/3/1999, (2) U.S. patent application serial no. 09/510,913, attorney docket no. 25791.7.02, filed on
10 2/23/2000, (3) U.S. patent application serial no. 09/502,350, attorney docket no. 25791.8.02, filed on 2/10/2000, (4) U.S. patent application serial no. 09/440,338, attorney docket no. 25791.9.02, filed on 11/15/1999, (5) U.S. patent application serial no. 09/523,460, attorney docket no. 25791.11.02, filed on 3/10/2000, (6) U.S. patent application serial no. 09/512,895, attorney docket no. 25791.12.02, filed on 2/24/2000,
15 (7) U.S. patent application serial no. 09/511,941, attorney docket no. 25791.16.02, filed on 2/24/2000, (8) U.S. patent application serial no. 09/588,946, attorney docket no. 25791.17.02, filed on 6/7/2000, (9) U.S. patent application serial no. 09/559,122, attorney docket no. 25791.23.02, filed on 4/26/2000, (10) PCT patent application serial no. PCT/US00/18635, attorney docket no. 25791.25.02, filed on 7/9/2000, (11) U.S. provisional patent application serial no. 60/162,671, attorney docket no. 25791.27, filed
20 on 11/1/1999, (12) U.S. provisional patent application serial no. 60/154,047, attorney docket no. 25791.29, filed on 9/16/1999, (13) U.S. provisional patent application serial no. 60/159,082, attorney docket no. 25791.34, filed on 10/12/1999, (14) U.S. provisional patent application serial no. 60/159,039, attorney docket no. 25791.36, filed
25 on 10/12/1999, (15) U.S. provisional patent application serial no. 60/159,033, attorney docket no. 25791.37, filed on 10/12/1999, (16) U.S. provisional patent application serial no. 60/212,359, attorney docket no. 25791.38, filed on 6/19/2000, (17) U.S. provisional patent application serial no. 60/165,228, attorney docket no. 25791.39, filed on
30 11/12/1999, (18) U.S. provisional patent application serial no. 60/221,443, attorney docket no. 25791.45, filed on 7/28/2000, (19) U.S. provisional patent application serial no. 60/221,645, attorney docket no. 25791.46, filed on 7/28/2000, (20) U.S. provisional patent application serial no. 60/233,638, attorney docket no. 25791.47, filed on
9/18/2000, (21) U.S. provisional patent application serial no. 60/237,334, attorney docket no. 25791.48, filed on 10/2/2000, (22) U.S. provisional patent application serial

no. 60/270,007, attorney docket no. 25791.50, filed on 2/20/2001, (23) U.S. provisional patent application serial no. 60/262,434, attorney docket no. 25791.51, filed on 1/17/2001, (24) U.S. provisional patent application serial no. 60/259,486, attorney docket no. 25791.52, filed on 1/3/2001, (25) U.S. provisional patent application serial
5 no. 60/303,740, attorney docket no. 25791.61, filed on 7/6/2001, (26) U.S. provisional patent application serial no. 60/313,453, attorney docket no. 25791.59, filed on 8/20/2001, (27) U.S. provisional patent application serial no. 60/317,985, attorney docket no. 25791.67, filed on 9/6/2001, (28) U.S. provisional patent application serial no. 60/3318,386, attorney docket no. 25791.67.02, filed on 9/10/2001, (29) U.S. utility
10 patent application serial no. 09/969,922, attorney docket no. 25791.69, filed on 10/3/2001, (30) U.S. utility patent application serial no. 10/016,467, attorney docket no. 25791.70, filed on 12/10/2001; (31) U.S. provisional patent application serial no. 60/343,674, attorney docket no. 25791.68, filed on 12/27/2001; (32) U.S. provisional patent application serial no. 60/346,309, attorney docket no. 25791.92, filed on
15 1/7/2002; (33) U.S. provisional patent application serial no. 60/372,048, attorney docket no. 25791.93, filed on 4/12/2002; (34) U.S. provisional patent application serial no. 60/372,632, attorney docket no. 25791.101, filed on 4/15/2002; and (35) U.S. provisional patent application serial no. 60/380,147, attorney docket no. 25791.104, filed on 5/6/2002, the disclosures of which are incorporated herein by reference.

20 **Background of the Invention**

This invention relates generally to oil and gas exploration, and in particular to forming and repairing wellbore casings to facilitate oil and gas exploration and production.

Conventionally, when a wellbore is created, a number of casings are installed in
25 the borehole to prevent collapse of the borehole wall and to prevent undesired outflow of drilling fluid into the formation or inflow of fluid from the formation into the borehole. The borehole is drilled in intervals whereby a casing which is to be installed in a lower borehole interval is lowered through a previously installed casing of an upper borehole interval. As a consequence of this procedure the casing of the lower interval is of
30 smaller diameter than the casing of the upper interval. Thus, the casings are in a nested arrangement with casing diameters decreasing in downward direction. Cement annuli are provided between the outer surfaces of the casings and the borehole wall to seal the casings from the borehole wall. As a consequence of this nested arrangement a relatively large borehole diameter is required at the upper part of the wellbore. Such

a large borehole diameter involves increased costs due to heavy casing handling equipment, large drill bits and increased volumes of drilling fluid and drill cuttings. Moreover, increased drilling rig time is involved due to required cement pumping, cement hardening, required equipment changes due to large variations in hole diameters drilled in the course of the well, and the large volume of cuttings drilled and removed.

The present invention is directed to overcoming one or more of the limitations of the existing processes for forming and repairing wellbore casings.

Summary of the Invention

According to one aspect of the present invention, a method of forming a mono diameter wellbore casing within a borehole that traverses a subterranean formation is provided that includes positioning a first wellbore casing within the borehole, radially expanding and plastically deforming the first wellbore casing within the borehole, positioning a second wellbore casing within the borehole in overlapping relation to the first wellbore casing, radially expanding and plastically deforming the second wellbore casing within the borehole, radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings, and radially expanding and plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore casing. The inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore casing is substantially equal to the inside diameter of the radially expanded and plastically deformed portions of the second wellbore casing. an apparatus and method for forming a mono diameter wellbore casing is provided.

According to another aspect of the present invention, an apparatus for forming a mono diameter wellbore casing is provided that includes means for positioning a first wellbore casing within the borehole, means for radially expanding and plastically deforming the first wellbore casing within the borehole, means for positioning a second wellbore casing within the borehole in overlapping relation to the first wellbore casing, means for radially expanding and plastically deforming the second wellbore casing within the borehole, means for radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings, and means for radially expanding and plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore casing, wherein the inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore

casing is substantially equal to the inside diameter of the radially expanded and plastically deformed portions of the second wellbore casing.

According to another aspect of the present invention, an apparatus for radially expanding and plastically deforming a tubular member is provided that includes a
5 tubular adapter defining a longitudinal passage, a tubular outer sleeve coupled to the tubular adapter defining a longitudinal passage, a tubular hydraulic slip body coupled to the tubular outer sleeve defining a plurality of L-shaped bypass ports and a plurality of radial hydraulic slip mounting passages, a plurality of hydraulic slips movably coupled and positioned within corresponding radial hydraulic slip mounting passages for
10 engaging the tubular member, a tubular packer cup mandrel coupled to the tubular hydraulic slip body defining a longitudinal passage, a plurality of packer cups coupled to the tubular packer cup mandrel for sealingly engaging the tubular member, a tubular shoe positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage, a tubular inner mandrel positioned within and movably coupled to
15 the tubular hydraulic slip body coupled to the tubular shoe defining a longitudinal passage and a plurality of radial bypass ports, a tubular expansion cone mandrel coupled to the tubular inner mandrel defining a longitudinal passage having a throat passage for receiving a ball, an L-shaped bypass port, and a radial pressure port, a tubular expansion cone coupled to the tubular expansion cone including a tapered
20 outer expansion surface for radially expanding and plastically deforming the tubular member, a tubular guide nose coupled to the tubular expansion cone mandrel defining a longitudinal passage, a bypass tube positioned within the tubular inner mandrel coupled to the expansion cone mandrel and the tubular shoe defining a longitudinal passage, and an annular longitudinal bypass passage defined between the tubular
25 inner mandrel and the bypass tube.

According to another aspect of the present invention, an apparatus for radially expanding and plastically deforming a tubular member is provided that includes a tubular support member defining a longitudinal passage, a tubular outer sleeve coupled to the tubular support member defining a longitudinal passage and a plurality of radial
30 bypass ports, an hydraulic slip coupled to the tubular outer sleeve for controllably engaging the tubular member, one or more packer cups coupled to the tubular outer sleeve for sealingly engaging the tubular member, a tubular inner sleeve positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage, an annular longitudinal bypass passage, and one or more radial bypass passages, and

Figs. 3a-3c are fragmentary cross-sectional illustrations of the apparatus of Figs. 2a-2c after activating the apparatus for forming a mono diameter wellbore casing to thereby radially expand the overlapping portions of the first and second wellbore casings.

5 Figs. 4a-4c are fragmentary cross-sectional illustrations of the apparatus of Figs. 3a-3c after deactivating and repositioning the apparatus for forming a mono diameter wellbore casing proximate another portion of the overlapping portion of the first and second wellbore casings.

10 Fig. 5a-5c are fragmentary cross sectional illustrations of the apparatus of Figs. 4a-4c after reactivating the apparatus for forming a mono diameter wellbore casing to thereby radially expand the other overlapping portions of the first and second wellbore casings and a non overlapping portion of the second wellbore casing.

15 Fig. 6 is a fragmentary cross-sectional illustration of the apparatus of Figs. 5a-5c after forming a mono diameter wellbore casing that includes the first and second wellbore casings.

Detailed Description of the Illustrative Embodiments

In an exemplary embodiment, as illustrated in Fig. 1, a borehole 10 that traverses a subterranean formation 12 includes a first wellbore casing 14 and a second wellbore casing 16. The borehole 10 may be positioned in any orientation, for example, from vertical to horizontal. The subterranean formation 12 may include, for example, a source of hydrocarbons and/or geothermal energy. In an exemplary embodiment, the first wellbore casing 14 is positioned within the borehole 10 and radially expanded and plastically deformed. The second wellbore casing 16 is then positioned within the borehole 10 in an overlapping relation to the first wellbore casing 14 and is then radially expanded and plastically deformed. As a result, the upper end of the second wellbore casing 16 is coupled to and positioned within the lower end of the first wellbore casing 14. The overlapping portions 18 of the first and second wellbore casings, 14 and 16, are thereby coupled to one another within the borehole 10.

30 In several exemplary embodiments, the first and second wellbore casings, 14 and 16, are radially expanded and plastically deformed in an overlapping relationship using one or more of the methods and apparatus disclosed in one or more of the following: (1) U.S. patent application serial no. 09/454,139, attorney docket no. 25791.03.02, filed on 12/3/1999, (2) U.S. patent application serial no. 09/510,913, attorney docket no. 25791.7.02, filed on 2/23/2000, (3) U.S. patent application serial

no. 09/502,350, attorney docket no. 25791.8.02, filed on 2/10/2000, (4) U.S. patent application serial no. 09/440,338, attorney docket no. 25791.9.02, filed on 11/15/1999, (5) U.S. patent application serial no. 09/523,460, attorney docket no. 25791.11.02, filed on 3/10/2000, (6) U.S. patent application serial no. 09/512,895, attorney docket no. 25791.12.02, filed on 2/24/2000, (7) U.S. patent application serial no. 09/511,941, attorney docket no. 25791.16.02, filed on 2/24/2000, (8) U.S. patent application serial no. 09/588,946, attorney docket no. 25791.17.02, filed on 6/7/2000, (9) U.S. patent application serial no. 09/559,122, attorney docket no. 25791.23.02, filed on 4/26/2000, (10) PCT patent application serial no. PCT/US00/18635, attorney docket no. 25791.25.02, filed on 7/9/2000, (11) U.S. provisional patent application serial no. 60/162,671, attorney docket no. 25791.27, filed on 11/1/1999, (12) U.S. provisional patent application serial no. 60/154,047, attorney docket no. 25791.29, filed on 9/16/1999, (13) U.S. provisional patent application serial no. 60/159,082, attorney docket no. 25791.34, filed on 10/12/1999, (14) U.S. provisional patent application serial no. 60/159,039, attorney docket no. 25791.36, filed on 10/12/1999, (15) U.S. provisional patent application serial no. 60/159,033, attorney docket no. 25791.37, filed on 10/12/1999, (16) U.S. provisional patent application serial no. 60/212,359, attorney docket no. 25791.38, filed on 6/19/2000, (17) U.S. provisional patent application serial no. 60/165,228, attorney docket no. 25791.39, filed on 11/12/1999, (18) U.S. provisional patent application serial no. 60/221,443, attorney docket no. 25791.45, filed on 7/28/2000, (19) U.S. provisional patent application serial no. 60/221,645, attorney docket no. 25791.46, filed on 7/28/2000, (20) U.S. provisional patent application serial no. 60/233,638, attorney docket no. 25791.47, filed on 9/18/2000, (21) U.S. provisional patent application serial no. 60/237,334, attorney docket no. 25791.48, filed on 10/2/2000, (22) U.S. provisional patent application serial no. 60/270,007, attorney docket no. 25791.50, filed on 2/20/2001, (23) U.S. provisional patent application serial no. 60/262,434, attorney docket no. 25791.51, filed on 1/17/2001, (24) U.S. provisional patent application serial no. 60/259,486, attorney docket no. 25791.52, filed on 1/3/2001, (25) U.S. provisional patent application serial no. 60/303,740, attorney docket no. 25791.61, filed on 7/6/2001, (26) U.S. provisional patent application serial no. 60/313,453, attorney docket no. 25791.59, filed on 8/20/2001, (27) U.S. provisional patent application serial no. 60/317,985, attorney docket no. 25791.67, filed on 9/6/2001, (28) U.S. provisional patent application serial no. 60/3318,386, attorney docket no. 25791.67.02, filed on 9/10/2001, (29) U.S. utility patent application serial no.

09/969,922, attorney docket no. 25791.69, filed on 10/3/2001, (30) U.S. utility patent application serial no. 10/016,467, attorney docket no. 25791.70, filed on 12/10/2001; (31) U.S. provisional patent application serial no. 60/343,674, attorney docket no. 25791.68, filed on 12/27/2001; (32) U.S. provisional patent application serial no. 60/346,309, attorney docket no 25791.92, filed on 1/7/2002; (33) U.S. provisional patent application serial no. 60/372,048, attorney docket no. 25791.93, filed on 4/12/2002; (34) U.S. provisional patent application serial no. 60/372,632, attorney docket no. 25791.101, filed on 4/15/2002; and (35) U.S. provisional patent application serial no. 60/380,147, attorney docket no. 25791.104, filed on 5/6/2002, the disclosures of which are incorporated herein by reference.

As illustrated in Figs. 2a-2d, in an exemplary embodiment, an apparatus 100 for forming a mono diameter wellbore casing is then positioned within the borehole 10 proximate the overlapping portions 18 of the first and second wellbore casing, 14 and 16, that includes a tubular support member 102 that defines a longitudinal passage 102a. An end 104a of a tubular adaptor 104 that defines a longitudinal passage 104b is threadably coupled to an end 102b of the tubular support member 102 that includes an external flange 104c having an externally recessed portion 104d at another end 104e that includes an externally tapered end face 104f. In an exemplary embodiment, the tubular support member 102 is a drill pipe.

An end 106a of a tubular outer sleeve 106 that defines a longitudinal passage 106b and a plurality of radial bypass ports 106c at another end 106d is threadably coupled to the recessed portion 104d of the external flange 104c of the end 104e of the tubular adaptor 104. An end 108a of a tubular hydraulic slip body 108 that defines a longitudinal passage 108b, a plurality of L-shaped bypass passages 108c, and a plurality of radial slip mounting passages 108d includes a recessed portion 108e that is threadably coupled to the 106d of the tubular outer sleeve 106 and a plurality of circumferentially spaced apart lugs 108f that are interleaved with the L-shaped bypass passages. Another end 108g of the tubular hydraulic slip body 108 includes an internally recessed portion 108h that is threadably coupled to an end 110a of a tubular packer cup mandrel 110 that defines a longitudinal passage 110b and includes a flange 110c at another end 110d that defines a recessed portion 110e and a plurality of radial passages 110f, and one or more lugs 110g.

As illustrated in Fig. 2d, a plurality of radially movable hydraulic slips 112 are movably coupled to and positioned within corresponding radial slip mounting passages

108d of the tubular hydraulic slip body 108 that each include slip base members 112a, spring members 112b, and slip engaging elements 112c. In an exemplary embodiment, the hydraulic slips 112 are round hydraulic slips that are hydraulically actuated when the internal pressure within the hydraulic slip body 108 pushes the hydraulic slips radially outwardly until the hydraulic slips are forced into engagement the internal diameters of the first and/or second wellbore casings, 14 and 16, thereby holding the hydraulic slips and all of the components rigidly attached to the hydraulic slips in place against external loads and pressure. In an exemplary embodiment, when the internal pressure within the hydraulic slip body 108 is reduced, the spring members 112b pull the slip engaging elements 112c away from the inside diameters of the first and/or second wellbore casings, 14 and 16. In an exemplary embodiment, the lugs 108f of the tubular hydraulic slip body 108 may engage the lugs 112f on the shoe 114 to allow transmission of torque when apparatus 100 is in extended position. In an exemplary embodiment, the tubular hydraulic slip body 108 also includes internal sealing members 108i that provide a fluidic seal between the tubular hydraulic slip body 108 and the inner mandrel 116.

A tubular shoe 114 that defines a longitudinal passage 114a and a recessed portion 114b at one end 114c is received within and mates with the longitudinal passage 106b of the tubular outer sleeve 106 that includes an internally tapered end face 114d at another end 114e and a plurality of circumferentially spaced apart lugs 114f at the one end. In an exemplary embodiment, the shoe 114 further includes one or more sealing members 114g for fluidically sealing the interface between the shoe and the tubular outer sleeve 106. An end 116a of an inner tubular mandrel 116 that defines a longitudinal passage 116b and a plurality of radial bypass ports 116c is threadably coupled to the recessed portion 114b at the one end 114c of the tubular shoe 114 and mates with the longitudinal passage 108b of the tubular hydraulic slip body 108. Another end 116d of the inner tubular mandrel 116 is threadably coupled to a recessed portion 118a of an end 118b of an expansion cone mandrel 118 that defines a longitudinal passage 118c having a throat passage 118d, an L-shaped bypass port 118e, and a radial pressure port 118f, and includes an external flange 118g, another recessed portion 118h, and lugs 118j.

A tubular expansion cone 120 that defines a longitudinal passage 120a mates with and is coupled to another end 118i of the expansion cone mandrel 118 proximate the external flange 118g that includes an outer expansion surface 120b for radially

expanding and plastically deforming the first and second wellbore casings, 14 and 16. In an exemplary embodiment, the maximum outside diameter of the outer expansion surface 120b of the tubular expansion cone 120 is substantially equal to the inside diameter of the first wellbore casing 14. A recessed portion 122a of an end 122b of a
5 tubular guide nose 122 that defines a longitudinal passage 122c is threadably coupled to the end 118i of the expansion cone mandrel 118 that includes a tapered end face 122d at another end 122e. In an exemplary embodiment, the tubular guide nose 122 helps to guide the apparatus 100 into the first and/or second wellbore casings, 14 and 16.

10 An end 124a of a tubular bypass tube 124 that defines a longitudinal passage 124b is received within and coupled to the recessed portion 118h of the expansion cone mandrel 118 and another end 124c of the tubular bypass tube is received within and coupled to a recess 114g in the end 114c of the tubular shoe 114. A tubular spacer 126, a first packer cup 128, a second spacer 130, a third spacer 132, and a
15 second packer cup 134 are sequentially mounted on the tubular packer cup mandrel 110 between the end 108g of the tubular hydraulic slip body 108 and the end 110d of the tubular packer cup mandrel 110. In an exemplary embodiment, the first and second packer cups, 128 and 134, resiliently engage and fluidically seal the interface with the interior surface of the first wellbore casing 14. In an exemplary embodiment,
20 the packer cups, 128 and 134, provide a fluidic seal between the apparatus 100 and the first and/or second wellbore casings, 14 and 16. In this manner, an annular chamber above the expansion cone 120 within the first and/or second wellbore casings, 14 and 16, may be pressurized for reasons to be described. In an exemplary embodiment, the lugs 110g on the end 110d of the packer cup mandrel 110 may
25 engage the lugs 118j on the end face of the flange 118g of the expansion cone mandrel 118 to allow the transmission of torque loads when the apparatus is in a collapsed position.

During the placement of the apparatus 100 within the borehole 10 proximate the overlapping portions 18 of the first and second wellbore casings, 14 and 16, fluidic
30 materials 200 within the borehole are conveyed through the longitudinal passages 122c, 118c, 124b, 104b, and 102a of the apparatus 100. In this manner, surge pressures within the borehole 10 are minimized during the insertion and placement of the apparatus 100 within the borehole.

As illustrated in Figs. 2b and 2c, in an exemplary embodiment, the apparatus 100

is positioned proximate the overlapping portions 18 of the first and second wellbore casings, 14 and 16, with the leading edge of the outer expansion surface 120b of the tubular expansion cone 120 positioned within the interior of the upper end of the second wellbore casing 16 and with the guide nose 122 mating with and extending into the interior of the upper end of the second wellbore casing. In this manner, the apparatus 100 is located and supported at least in part by the upper end of the second wellbore casing 16. Furthermore, in this manner, the apparatus 100 is centrally positioned within the first and second wellbore casings, 14 and 16.

In an exemplary embodiment, as illustrated in Figs. 3a-3c, a ball 202 is then positioned within the throat passage 118d of the longitudinal passage 118c of the expansion cone mandrel 118 by injecting a fluidic material 204 into the apparatus 100 through the longitudinal passages 102a, 104b, 106b, 114a, 124b, and 118c. The injected fluidic material 204 is also conveyed through the radial pressure ports 118f of the expansion cone mandrel 118 into an annular chamber 206 above the external flange 118g of the expansion cone mandrel and then into the longitudinal passages 110b and 108b of the packer cup mandrel 110 and hydraulic slip body 108, respectively, and into the radial slip mounting passages 108d of the hydraulic slip body. Continued injection of the fluidic material 204 into the apparatus 100 through the longitudinal passages 102a, 104b, 106b, 114a, 124b, and 118c pressurizes the annular chamber 206 and the radial slip mounting passages 108d thereby displacing the expansion cone mandrel 118, the expansion cone 120, and the guide nose 122 downwardly in the longitudinal direction and displacing the hydraulic slips 112 outwardly in the radial direction.

In particular, the outward radial displacement of the hydraulic slips 112 causes the hydraulic slips to engage in the interior surface of the first wellbore casing 14 thereby fixing the position of the tubular support member 102, the tubular adaptor 104, the hydraulic slip body 108, the packer cup mandrel 110, the spacer 126, the packer cup 128, the spacer 130, the spacer 132, and the packer cup 134 relative to the first wellbore casing. As a result, the shoe 114, the inner mandrel 116, the expansion cone mandrel 118, the expansion cone 120, the guide nose 122, and the bypass tube 124 are then displaced downwardly relative to the tubular support member 102, the tubular adaptor 104, the hydraulic slip body 108, the packer cup mandrel 110, the spacer 126, the packer cup 128, the spacer 130, the spacer 132, and the packer cup 134 by the pressurization of the annular chamber 206.

The downward longitudinal displacement of the expansion cone 120 radially expands and plastically deforms the overlapping portions 18 of the first and second wellbore casings, 14 and 16. As a result of the radial expansion and plastic deformation, the inside diameter of the portion of the second wellbore casing 16 that overlaps with the first wellbore casing 14 is then substantially equal to the inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore casing.

During the downward longitudinal displacement of the expansion cone mandrel 118, the expansion cone 120, and the guide nose 122, fluidic materials 208 within the second wellbore casing 16 that are displaced by the downward longitudinal displacement of the expansion cone mandrel, the expansion cone, and the guide nose are conveyed through the bypass port 118e of the expansion cone mandrel, the annular bypass passage 210 defined between the inner mandrel 116 and the bypass tube 124, the bypass ports 116c of the inner mandrel, the bypass ports 108c of the hydraulic slip body 108, and the bypass ports 106c of the outer sleeve 106 out of the apparatus 100.

In an exemplary embodiment, during the pressurization of the annular chamber 206, the packer cups 128 and 134 provide a fluidic seal between the apparatus 100 and the first and second wellbore casings, 14 and 16. Furthermore, during the pressurization of the annular chamber 206, the interface between the tubular expansion cone 120 and the first and/or second wellbore casings, 14 and 16, is not fluid tight. In this manner, lubricants that may be provided in the injected fluidic materials 204 may be conveyed to the leading edge of the interface between the expansion surface 120b and the first and/or second wellbore casing, 14 and 16, in order to minimize frictional forces and thereby enhance the operation efficiency of the operation.

In an exemplary embodiment, as illustrated in Fig. 3a, the shoe 114, the inner mandrel 116, the expansion cone mandrel 118, the expansion cone 120, the guide nose 122, and the bypass tube 124 are then displaced downwardly relative to the tubular support member 102, the tubular adaptor 104, the hydraulic slip body 108, the packer cup mandrel 110, the spacer 126, the packer cup 128, the spacer 130, the spacer 132, and the packer cup 134 by the pressurization of the annular chamber 206 until the lugs 114f of the shoe impact the hydraulic slip body 108. At this point, in an exemplary embodiment, the operating pressure within the annular chamber 206 will

increase suddenly thereby indicating that the expansion cone 120 has reached the end of the expansion stroke.

In an exemplary embodiment, as illustrated in Figs. 4a-4c, once the expansion cone 120 has reached the end of the expansion stroke, the operating pressures of the annular chamber 206 and the radial slip mounting passages 108d are reduced by
5 stopping the injection of the fluidic material 204 into the apparatus 100 and/or by activating one or more pressure relief valves 210 at a surface location to relieve the operating pressures in the annular chamber and radial slip mounting passages to atmospheric. As a result of the pressure relief of the operating pressures of the
10 annular chamber 206 and the radial slip mounting passages 108d, the hydraulic slips 112 may be displaced inwardly in the radial direction thereby disengaging the hydraulic slip body 108 from the first wellbore casing 14. Furthermore, as a result of the pressure relief of the operating pressures of the annular chamber 206 and the radial slip mounting passages 108d, the support member 102, the adapter 104, the outer sleeve 106, the hydraulic slip body 108, the packer cup mandrel 110, the hydraulic
15 slips 112, the spacer 126, the first packer cup 128, the spacer 130, the spacer 132, and the second packer cup 134 may then be displaced downwardly in the longitudinal direction relative to the shoe 114, the inner mandrel 116, the expansion cone mandrel 118, the expansion cone 120, the guide nose 122, and the bypass tube 124 until the
20 internally tapered end face 114d of the shoe 114 impacts the of the external tapered end face 104f of the adapter 104. In this manner, the apparatus 100 is placed in a collapsed position.

In an exemplary embodiment, as illustrated in Figs. 5a-5c, the fluidic material 204 is once again injected into the apparatus 100 through the longitudinal passages 102a,
25 104b, 106b, 114a, 124b, and 118c. The injected fluidic material 204 is also conveyed through the radial pressure ports 118f of the expansion cone mandrel 118 into an annular chamber 206 above the external flange 118g of the expansion cone mandrel and then into the longitudinal passages 110b and 108b of the packer cup mandrel 110 and hydraulic slip body 108, respectively, and into the radial slip mounting passages
30 108d of the hydraulic slip body. Continued injection of the fluidic material 204 into the apparatus 100 through the longitudinal passages 102a, 104b, 106b, 114a, 124b, and 118c pressurizes the annular chamber 206 and the radial slip mounting passages 108d thereby displacing the expansion cone mandrel 118, the expansion cone 120, and the guide nose 122 downwardly in the longitudinal direction and displacing the hydraulic

slips 112 outwardly in the radial direction.

In particular, the outward radial displacement of the hydraulic slips 112 causes the hydraulic slips to engage in the interior surface of the first wellbore casing 14 thereby fixing the position of the tubular support member 102, the tubular adaptor 104, the hydraulic slip body 108, the packer cup mandrel 110, the spacer 126, the packer cup 128, the spacer 130, the spacer 132, and the packer cup 134 relative to the first wellbore casing. As a result, the shoe 114, the inner mandrel 116, the expansion cone mandrel 118, the expansion cone 120, the guide nose 122, and the bypass tube 124 are then displaced downwardly relative to the tubular support member 102, the tubular adaptor 104, the hydraulic slip body 108, the packer cup mandrel 110, the spacer 126, the packer cup 128, the spacer 130, the spacer 132, and the packer cup 134 by the pressurization of the annular chamber 206.

The downward longitudinal displacement of the expansion cone 120 radially expands and plastically deforms the remaining portion of the overlapping portions 18 of the first and second wellbore casings, 14 and 16, and a non-overlapping portion of the second wellbore casing 16. As a result of the radial expansion and plastic deformation, the inside diameter of the portion of the second wellbore casing 16 that overlaps with the first wellbore casing 14 is then substantially equal to the inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore casing. Furthermore, as a result of the radial expansion and plastic deformation, the inside diameter of at least a portion of the second wellbore casing 16 that does not overlap with the first wellbore casing 14 is substantially equal to the inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore casing.

During the downward longitudinal displacement of the expansion cone mandrel 118, the expansion cone 120, and the guide nose 122, fluidic materials 208 within the second wellbore casing 16 that are displaced by the downward longitudinal displacement of the expansion cone mandrel, the expansion cone, and the guide nose are conveyed through the bypass port 118e of the expansion cone mandrel, the annular passage 210 defined between the inner mandrel 116 and the bypass tube 124, the bypass ports 116c of the inner mandrel, the bypass ports 108c of the hydraulic slip body 108, and the bypass ports 106c of the outer sleeve 106 out of the apparatus 100.

In an exemplary embodiment, during the pressurization of the annular chamber 206, the packer cups 128 and 134 provide a fluidic seal between the apparatus 100

and the first and second wellbore casings, 14 and 16. Furthermore, during the pressurization of the annular chamber 206, the interface between the tubular expansion cone 120 and the first and/or second wellbore casings, 14 and 16, is not fluid tight. In this manner, lubricants that may be provided in the injected fluidic materials 204 may be conveyed to the leading edge of the interface between the expansion surface 120b and the first and/or second wellbore casing, 14 and 16, in order to minimize frictional forces and thereby enhance the operation efficiency of the operation.

In an exemplary embodiment, as illustrated in Fig. 5b, the shoe 114, the inner mandrel 116, the expansion cone mandrel 118, the expansion cone 120, the guide nose 122, and the bypass tube 124 are then displaced downwardly relative to the tubular support member 102, the tubular adaptor 104, the hydraulic slip body 108, the packer cup mandrel 110, the spacer 126, the packer cup 128, the spacer 130, the spacer 132, and the packer cup 134 by the pressurization of the annular chamber 206 until the lugs 114f of the shoe impact the hydraulic slip body 108. At this point, in an exemplary embodiment, the operating pressure within the annular chamber 206 will increase suddenly thereby indicating that the expansion cone 120 has reached the end of the expansion stroke.

As illustrated in Fig. 6, in an exemplary embodiment, the operations of Figs. 3a-3c, 4a-4c, and 5a-5c, may then be repeated to thereby radially expand and plastically deform the remaining portions of the second wellbore casing 16 that do not overlap with the first wellbore casing 14. As a result, a mono diameter wellbore casing is constructed that includes the first and second wellbore casings, 14 and 16. The inside diameter of the first wellbore casing ID_{14} is substantially equal to the inside diameter of the second wellbore casing ID_{16} .

The illustrative embodiments provide the advantage of expanding the casing without applying pressure to the entire casing string and allowing easy retrieval of the expansion apparatus 100 if expansion problems develop.

In several alternative embodiments, the expansion cone 120 may be an expandable adjustable expansion cone.

In several alternative embodiments, other sealing methods and apparatus between the apparatus 100 and the inside diameters of the first and/or second wellbore casings, 14 and 16, may be used. For example, hydraulically and/or mechanically actuated packer elements and/or mechanical slips with drag blocks and J-slots may be

used in place of the hydraulic slips 112 to hold the tubular hydraulic slip body 108 in a stationary position during the radial expansion process.

In several alternative embodiments, the apparatus 100 can also be used for single stage top-down expansion of cased and open hole liners and as a liner hanger.

5 In an exemplary embodiment, the expansion cone 120, the packer cups, 128 and 134, and the hydraulic slips 112 are run in an expansion cone launcher as disclosed in one or more of the following: (1) U.S. patent application serial no. 09/454,139, attorney docket no. 25791.03.02, filed on 12/3/1999, (2) U.S. patent application serial no. 09/510,913, attorney docket no. 25791.7.02, filed on 2/23/2000, (3) U.S. patent
10 application serial no. 09/502,350, attorney docket no. 25791.8.02, filed on 2/10/2000, (4) U.S. patent application serial no. 09/440,338, attorney docket no. 25791.9.02, filed on 11/15/1999, (5) U.S. patent application serial no. 09/523,460, attorney docket no. 25791.11.02, filed on 3/10/2000, (6) U.S. patent application serial no. 09/512,895, attorney docket no. 25791.12.02, filed on 2/24/2000, (7) U.S. patent application serial
15 no. 09/511,941, attorney docket no. 25791.16.02, filed on 2/24/2000, (8) U.S. patent application serial no. 09/588,946, attorney docket no. 25791.17.02, filed on 6/7/2000, (9) U.S. patent application serial no. 09/559,122, attorney docket no. 25791.23.02, filed on 4/26/2000, (10) PCT patent application serial no. PCT/US00/18635, attorney docket no. 25791.25.02, filed on 7/9/2000, (11) U.S. provisional patent application serial no.
20 60/162,671, attorney docket no. 25791.27, filed on 11/1/1999, (12) U.S. provisional patent application serial no. 60/154,047, attorney docket no. 25791.29, filed on 9/16/1999, (13) U.S. provisional patent application serial no. 60/159,082, attorney docket no. 25791.34, filed on 10/12/1999, (14) U.S. provisional patent application serial no. 60/159,039, attorney docket no. 25791.36, filed on 10/12/1999, (15) U.S.
25 provisional patent application serial no. 60/159,033, attorney docket no. 25791.37, filed on 10/12/1999, (16) U.S. provisional patent application serial no. 60/212,359, attorney docket no. 25791.38, filed on 6/19/2000, (17) U.S. provisional patent application serial no. 60/165,228, attorney docket no. 25791.39, filed on 11/12/1999, (18) U.S. provisional patent application serial no. 60/221,443, attorney docket no. 25791.45, filed
30 on 7/28/2000, (19) U.S. provisional patent application serial no. 60/221,645, attorney docket no. 25791.46, filed on 7/28/2000, (20) U.S. provisional patent application serial no. 60/233,638, attorney docket no. 25791.47, filed on 9/18/2000, (21) U.S. provisional patent application serial no. 60/237,334, attorney docket no. 25791.48, filed on 10/2/2000, (22) U.S. provisional patent application serial no. 60/270,007, attorney

docket no. 25791.50, filed on 2/20/2001, (23) U.S. provisional patent application serial no. 60/262,434, attorney docket no. 25791.51, filed on 1/17/2001, (24) U.S. provisional patent application serial no. 60/259,486, attorney docket no. 25791.52, filed on 1/3/2001, (25) U.S. provisional patent application serial no. 60/303,740, attorney docket
5 no. 25791.61, filed on 7/6/2001, (26) U.S. provisional patent application serial no. 60/313,453, attorney docket no. 25791.59, filed on 8/20/2001, (27) U.S. provisional patent application serial no. 60/317,985, attorney docket no. 25791.67, filed on 9/6/2001, (28) U.S. provisional patent application serial no. 60/3318,386, attorney docket no. 25791.67.02, filed on 9/10/2001, (29) U.S. utility patent application serial no.
10 09/969,922, attorney docket no. 25791.69, filed on 10/3/2001, (30) U.S. utility patent application serial no. 10/016,467, attorney docket no. 25791.70, filed on 12/10/2001; (31) U.S. provisional patent application serial no. 60/343,674, attorney docket no. 25791.68, filed on 12/27/2001; (32) U.S. provisional patent application serial no. 60/346,309, attorney docket no 25791.92, filed on 1/7/2002; (33) U.S. provisional
15 patent application serial no. 60/372,048, attorney docket no. 25791.93, filed on 4/12/2002; (34) U.S. provisional patent application serial no. 60/372,632, attorney docket no. 25791.101, filed on 4/15/2002; and (35) U.S. provisional patent application serial no. 60/380,147, attorney docket no. 25791.104, filed on 5/6/2002, the disclosures of which are incorporated herein by reference.

20 The first stroke of the expansion cone 120 expands the expandable casing out to contact the well casing with enough force to hold the weight of the expandable casing string or liner. Pressure is then released and the expansion assy is moved down to the collapsed position and the expansion process repeated.

 A method of forming a mono diameter wellbore casing within a borehole that
25 traverses a subterranean formation has been described that includes positioning a first wellbore casing within the borehole, radially expanding and plastically deforming the first wellbore casing within the borehole, positioning a second wellbore casing within the borehole in overlapping relation to the first wellbore casing, radially expanding and plastically deforming the second wellbore casing within the borehole, radially
30 expanding and plastically deforming the overlapping portions of the first and second wellbore casings, and radially expanding and plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore casing. The inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore casing is substantially equal to the inside diameter of the radially

expanded and plastically deformed portions of the second wellbore casing. In an exemplary embodiment, the radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings includes positioning a telescoping radial expansion device comprising an outer sleeve and an inner sleeve
5 positioned within and movably coupled to the outer sleeve comprising a tubular expansion cone proximate the end of the second wellbore casing, and injecting a fluidic material into the telescoping radial expansion device to cause the outer sleeve to engage the first wellbore casing and cause the inner sleeve to extend out of the outer sleeve into the overlapping portions of the first and second wellbore casings to cause
10 the tubular expansion cone to radially expand and plastically deform the overlapping portions of the first and second wellbore casings. In an exemplary embodiment, the method further includes conveying fluidic materials within the borehole that are displaced by the extension of the inner sleeve to a location within the borehole above the tubular expansion cone. In an exemplary embodiment, radially expanding and
15 plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore casing includes reducing the operating pressure within the telescoping radial expansion device, moving the outer sleeve onto the inner sleeve of the telescoping radial expansion device, and injecting a fluidic material into the telescoping radial expansion device to cause the outer sleeve to engage at least one of
20 the first and second wellbore casings and cause the inner sleeve to extend out of the outer sleeve into the second wellbore casing to cause the tubular expansion cone to radially expand and plastically deform at least a portion of the second wellbore casing. In an exemplary embodiment, the method further includes conveying fluidic materials within the borehole that are displaced by the extension of the inner sleeve to a location
25 within the borehole above the tubular expansion cone.

An apparatus for forming a mono diameter wellbore casing has been described that includes means for positioning a first wellbore casing within the borehole, means for radially expanding and plastically deforming the first wellbore casing within the borehole, means for positioning a second wellbore casing within the borehole in
30 overlapping relation to the first wellbore casing, means for radially expanding and plastically deforming the second wellbore casing within the borehole, means for radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings, and means for radially expanding and plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore

casing. The inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore casing is substantially equal to the inside diameter of the radially expanded and plastically deformed portions of the second wellbore casing. In an exemplary embodiment, the means for radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings includes means for positioning a telescoping radial expansion device comprising an outer sleeve and an inner sleeve positioned within and movably coupled to the outer sleeve comprising a tubular expansion cone proximate the end of the second wellbore casing, and means for injecting a fluidic material into the telescoping radial expansion device to cause the outer sleeve to engage the first wellbore casing and cause the inner sleeve to extend out of the outer sleeve into the overlapping portions of the first and second wellbore casings to cause the tubular expansion cone to radially expand and plastically deform the overlapping portions of the first and second wellbore casings. In an exemplary embodiment, the method further includes conveying fluidic materials within the borehole that are displaced by the extension of the inner sleeve to a location within the borehole above the tubular expansion cone. In an exemplary embodiment, the means for radially expanding and plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore casing includes means for reducing the operating pressure within the telescoping radial expansion device, means for moving the outer sleeve onto the inner sleeve of the telescoping radial expansion device, and means for injecting a fluidic material into the telescoping radial expansion device to cause the outer sleeve to engage at least one of the first and second wellbore casings and cause the inner sleeve to extend out of the outer sleeve into the second wellbore casing to cause the tubular expansion cone to radially expand and plastically deform at least a portion of the second wellbore casing. In an exemplary embodiment, the method further includes conveying fluidic materials within the borehole that are displaced by the extension of the inner sleeve to a location within the borehole above the tubular expansion cone.

An apparatus for radially expanding and plastically deforming a tubular member has been described that includes a tubular adapter defining a longitudinal passage, a tubular outer sleeve coupled to the tubular adapter defining a longitudinal passage, a tubular hydraulic slip body coupled to the tubular outer sleeve defining a plurality of L-shaped bypass ports and a plurality of radial hydraulic slip mounting passages, a plurality of hydraulic slips movably coupled and positioned within corresponding radial

hydraulic slip mounting passages for engaging the tubular member, a tubular packer cup mandrel coupled to the tubular hydraulic slip body defining a longitudinal passage, a plurality of packer cups coupled to the tubular packer cup mandrel for sealingly engaging the tubular member, a tubular shoe positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage, a tubular inner mandrel positioned within and movably coupled to the tubular hydraulic slip body coupled to the tubular shoe defining a longitudinal passage and a plurality of radial bypass ports, a tubular expansion cone mandrel coupled to the tubular inner mandrel defining a longitudinal passage having a throat passage for receiving a ball, an L-shaped bypass port, and a radial pressure port, a tubular expansion cone coupled to the tubular expansion cone including a tapered outer expansion surface for radially expanding and plastically deforming the tubular member, a tubular guide nose coupled to the tubular expansion cone mandrel defining a longitudinal passage, a bypass tube positioned within the tubular inner mandrel coupled to the expansion cone mandrel and the tubular shoe defining a longitudinal passage, and an annular longitudinal bypass passage defined between the tubular inner mandrel and the bypass tube. In an exemplary embodiment, the longitudinal passages of the tubular adapter, bypass tube, and tubular expansion cone mandrel are fluidically coupled. In an exemplary embodiment, the longitudinal passage of the tubular expansion cone mandrel is fluidically coupled to the radial pressure port of the tubular expansion cone mandrel. In an exemplary embodiment, the L-shaped bypass port of the tubular expansion cone mandrel is fluidically coupled to the annular longitudinal bypass passage, the radial bypass passages of the tubular inner mandrel, the L-shaped bypass ports of the tubular hydraulic slip body, and the radial bypass ports of the tubular outer sleeve.

An apparatus for radially expanding and plastically deforming a tubular member has been described that includes a tubular support member defining a longitudinal passage, a tubular outer sleeve coupled to the tubular support member defining a longitudinal passage and a plurality of radial bypass ports, an hydraulic slip coupled to the tubular outer sleeve for controllably engaging the tubular member, one or more packer cups coupled to the tubular outer sleeve for sealingly engaging the tubular member, a tubular inner sleeve positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage, an annular longitudinal bypass passage, and one or more radial bypass passages, and a tubular expansion cone coupled to the tubular inner sleeve defining a longitudinal passage having a throat passage for

receiving a ball, an L-shaped bypass port, and a radial pressure port including an tapered outer expansion surface for radially expanding and plastically deforming the tubular member. In an exemplary embodiment, the longitudinal passages of the tubular outer sleeve and the tubular expansion cone are fluidicly coupled. In an
5 exemplary embodiment, the longitudinal passage of the tubular expansion cone is fluidicly coupled to the radial pressure port of the tubular expansion cone. In an exemplary embodiment, the L-shaped bypass port of the tubular expansion cone is fluidicly coupled to the annular longitudinal bypass passage and the radial bypass passages of the tubular inner sleeve, and the L-shaped bypass ports and the radial
10 bypass ports of the tubular outer sleeve.

A method of radially expanding and plastically deforming a wellbore casing positioned within a borehole that traverses a subterranean formation has been described that includes positioning an outer tubular sleeve and an inner tubular sleeve comprising an expansion cone within the borehole, wherein the inner tubular sleeve is
15 movably coupled to and at least partially housed within the outer tubular sleeve, injecting a fluidic material into the inner and outer tubular sleeves, coupling the outer tubular sleeve to the wellbore casing, and extending the inner tubular sleeve out of the outer tubular sleeve into the wellbore casing to radially expand and plastically deform a portion of the wellbore casing using the expansion cone. In an exemplary embodiment,
20 injecting a fluidic material into the inner and outer tubular sleeves includes injecting the fluidic material into an annular chamber above the expansion cone. In an exemplary embodiment, the method further includes conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve to a location above the expansion cone. In an exemplary embodiment, conveying fluidic materials within the
25 borehole displaced by the extension of the inner tubular sleeve above the expansion cone includes conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve through an annular passage and one or more radial passages to the location above the expansion cone. In an exemplary embodiment, the method further includes depressuring the inner and outer tubular
30 sleeves, decoupling the outer tubular sleeve and the wellbore casing, and collapsing the outer tubular sleeve onto the inner tubular sleeve. In an exemplary embodiment, the method further includes injecting a fluidic material into the inner and outer tubular sleeves, coupling the outer tubular sleeve to the wellbore casing, and extending the inner tubular sleeve out of the outer tubular sleeve into the wellbore casing to radially

expand and plastically deform another portion of the wellbore casing. In an exemplary embodiment, injecting a fluidic material into the inner and outer tubular sleeves includes injecting the fluidic material into an annular chamber above the expansion cone. In an exemplary embodiment, the method further includes conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve to a location above the expansion cone. In an exemplary embodiment, conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve above the expansion cone includes conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve through an annular passage and one or more radial passages to the location above the expansion cone.

An apparatus for radially expanding and plastically deforming a wellbore casing positioned within a borehole that traverses a subterranean formation has been described that includes means for positioning an outer tubular sleeve and an inner tubular sleeve comprising an expansion cone within the borehole, wherein the inner tubular sleeve is movably coupled to and at least partially housed within the outer tubular sleeve, means for injecting a fluidic material into the inner and outer tubular sleeves, means for coupling the outer tubular sleeve to the wellbore casing, and means for extending the inner tubular sleeve out of the outer tubular sleeve into the wellbore casing to radially expand and plastically deform a portion of the wellbore casing using the expansion cone. In an exemplary embodiment, the means for injecting a fluidic material into the inner and outer tubular sleeves includes means for injecting the fluidic material into an annular chamber above the expansion cone. In an exemplary embodiment, the apparatus further includes means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve to a location above the expansion cone. In an exemplary embodiment, the means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve above the expansion cone includes means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve through an annular passage and one or more radial passages to the location above the expansion cone. In an exemplary embodiment, the apparatus further includes means for depressuring the inner and outer tubular sleeves, means for decoupling the outer tubular sleeve and the wellbore casing, and means for collapsing the outer tubular sleeve onto the inner tubular sleeve. In an exemplary embodiment, the apparatus further includes means for injecting a fluidic material into the inner and outer tubular sleeves, means for coupling

the outer tubular sleeve to the wellbore casing, means for extending the inner tubular sleeve out of the outer tubular sleeve into the wellbore casing to radially expand and plastically deform another portion of the wellbore casing. In an exemplary embodiment, the means for injecting a fluidic material into the inner and outer tubular sleeves includes means for injecting the fluidic material into an annular chamber above the expansion cone. In an exemplary embodiment, the apparatus further includes means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve to a location above the expansion cone. In an exemplary embodiment, the means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve above the expansion cone includes means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve through an annular passage and one or more radial passages to the location above the expansion cone.

It is understood that variations may be made in the foregoing without departing from the scope of the invention. For example, the teachings of the present illustrative embodiments may be used to provide a wellbore casing, a pipeline, or a structural support. Furthermore, the elements and teachings of the various illustrative embodiments may be combined in whole or in part in some or all of the illustrative embodiments.

Although illustrative embodiments of the invention have been shown and described, a wide range of modification, changes and substitution is contemplated in the foregoing disclosure. In some instances, some features of the present invention may be employed without a corresponding use of the other features. Accordingly, it is appropriate that the appended claims be construed broadly and in a manner consistent with the scope of the invention.

CLAIMS

1. An apparatus for radially expanding and plastically deforming a tubular member,
5 comprising:
 - a tubular support member defining a longitudinal passage;
 - a tubular outer sleeve coupled to the tubular support member defining a longitudinal passage and a plurality of radial bypass ports;
 - an hydraulic slip coupled to the tubular outer sleeve for controllably engaging the
10 tubular member;
 - one or more packer cups coupled to the tubular outer sleeve for sealingly engaging the tubular member;
 - a tubular inner sleeve positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage, an annular longitudinal bypass passage, and
15 one or more radial bypass passages; and
 - a tubular expansion cone coupled to the tubular inner sleeve defining a longitudinal passage having a throat passage for receiving a ball, an L-shaped bypass port, and a radial pressure port including a tapered outer expansion surface for radially expanding and plastically deforming the tubular member.
20
2. The apparatus of claim 1, wherein the longitudinal passages of the tubular outer sleeve and the tubular expansion cone are fluidicly coupled.
3. The apparatus of claim 1, wherein the longitudinal passage of the tubular
25 expansion cone is fluidicly coupled to the radial pressure port of the tubular expansion cone.
4. The apparatus of claim 1, wherein the L-shaped bypass port of the tubular expansion cone is fluidicly coupled to the annular longitudinal bypass passage and the
30 radial bypass passages of the tubular inner sleeve, and the L-shaped bypass ports and the radial bypass ports of the tubular outer sleeve.

What is claimed is:

1. A method of forming a mono diameter wellbore casing within a borehole that traverses a subterranean formation, comprising:
 - 5 positioning a first wellbore casing within the borehole;
radially expanding and plastically deforming the first wellbore casing within the borehole;
positioning a second wellbore casing within the borehole in overlapping relation to the first wellbore casing;
10 radially expanding and plastically deforming the second wellbore casing within the borehole;
radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings; and
radially expanding and plastically deforming at least a portion of the second
15 wellbore casing that does not overlap with the first wellbore casing;
wherein the inside diameter of the portion of the first wellbore casing that does not overlap with the second wellbore casing is substantially equal to the inside diameter of the radially expanded and plastically deformed portions of the second wellbore casing.
- 20 2. The method of claim 1, wherein radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings comprises:
 - positioning a telescoping radial expansion device comprising an outer sleeve and an inner sleeve positioned within and movably coupled to the outer sleeve comprising a tubular expansion cone proximate the end of the
25 second wellbore casing; and
injecting a fluidic material into the telescoping radial expansion device to cause the outer sleeve to engage the first wellbore casing and cause the inner sleeve to extend out of the outer sleeve into the overlapping portions of the first and second wellbore casings to cause the tubular expansion
30 cone to radially expand and plastically deform the overlapping portions of the first and second wellbore casings.
3. The method of claim 2, further comprising:
 - conveying fluidic materials within the borehole that are displaced by the extension of the inner sleeve to a location within the borehole above the

tubular expansion cone.

4. The method of claim 2, wherein radially expanding and plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore casing comprises:

5 reducing the operating pressure within the telescoping radial expansion device;
moving the outer sleeve onto the inner sleeve of the telescoping radial
expansion device; and
injecting a fluidic material into the telescoping radial expansion device to cause
the outer sleeve to engage at least one of the first and second wellbore
10 casings and cause the inner sleeve to extend out of the outer sleeve into
the second wellbore casing to cause the tubular expansion cone to
radially expand and plastically deform at least a portion of the second
wellbore casing.

5. The method of claim 4, further comprising:

15 conveying fluidic materials within the borehole that are displaced by the
extension of the inner sleeve to a location within the borehole above the
tubular expansion cone.

6. An apparatus for forming a mono diameter wellbore casing, comprising:

means for positioning a first wellbore casing within the borehole;
20 means for radially expanding and plastically deforming the first wellbore casing
within the borehole;
means for positioning a second wellbore casing within the borehole in
overlapping relation to the first wellbore casing;
means for radially expanding and plastically deforming the second wellbore
25 casing within the borehole;
means for radially expanding and plastically deforming the overlapping portions
of the first and second wellbore casings; and
means for radially expanding and plastically deforming at least a portion of the
second wellbore casing that does not overlap with the first wellbore
30 casing;
wherein the inside diameter of the portion of the first wellbore casing that does
not overlap with the second wellbore casing is substantially equal to the
inside diameter of the radially expanded and plastically deformed
portions of the second wellbore casing.

7. The apparatus of claim 6, wherein means for radially expanding and plastically deforming the overlapping portions of the first and second wellbore casings comprises:
- means for positioning a telescoping radial expansion device comprising an outer sleeve and an inner sleeve positioned within and movably coupled to the outer sleeve comprising a tubular expansion cone proximate the end of the second wellbore casing; and
- means for injecting a fluidic material into the telescoping radial expansion device to cause the outer sleeve to engage the first wellbore casing and cause the inner sleeve to extend out of the outer sleeve into the overlapping portions of the first and second wellbore casings to cause the tubular expansion cone to radially expand and plastically deform the overlapping portions of the first and second wellbore casings.
8. The method of claim 7, further comprising:
- conveying fluidic materials within the borehole that are displaced by the extension of the inner sleeve to a location within the borehole above the tubular expansion cone.
9. The apparatus of claim 7, wherein means for radially expanding and plastically deforming at least a portion of the second wellbore casing that does not overlap with the first wellbore casing comprises:
- means for reducing the operating pressure within the telescoping radial expansion device;
- means for moving the outer sleeve onto the inner sleeve of the telescoping radial expansion device; and
- means for injecting a fluidic material into the telescoping radial expansion device to cause the outer sleeve to engage at least one of the first and second wellbore casings and cause the inner sleeve to extend out of the outer sleeve into the second wellbore casing to cause the tubular expansion cone to radially expand and plastically deform at least a portion of the second wellbore casing.
10. The method of claim 9, further comprising:
- conveying fluidic materials within the borehole that are displaced by the extension of the inner sleeve to a location within the borehole above the tubular expansion cone.
11. An apparatus for radially expanding and plastically deforming a tubular member,

comprising:

- a tubular adapter defining a longitudinal passage;
- a tubular outer sleeve coupled to the tubular adapter defining a longitudinal passage;
- 5 a tubular hydraulic slip body coupled to the tubular outer sleeve defining a plurality of L-shaped bypass ports and a plurality of radial hydraulic slip mounting passages;
- a plurality of hydraulic slips movably coupled and positioned within corresponding radial hydraulic slip mounting passages for engaging the tubular member;
- 10 a tubular packer cup mandrel coupled to the tubular hydraulic slip body defining a longitudinal passage;
- a plurality of packer cups coupled to the tubular packer cup mandrel for sealingly engaging the tubular member;
- 15 a tubular shoe positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage;
- a tubular inner mandrel positioned within and movably coupled to the tubular hydraulic slip body coupled to the tubular shoe defining a longitudinal passage and a plurality of radial bypass ports;
- 20 a tubular expansion cone mandrel coupled to the tubular inner mandrel defining a longitudinal passage having a throat passage for receiving a ball, an L-shaped bypass port, and a radial pressure port;
- a tubular expansion cone coupled to the tubular expansion cone mandrel including a tapered outer expansion surface for radially expanding and plastically deforming the tubular member;
- 25 a tubular guide nose coupled to the tubular expansion cone mandrel defining a longitudinal passage;
- a bypass tube positioned within the tubular inner mandrel coupled to the expansion cone mandrel and the tubular shoe defining a longitudinal passage;
- 30 an annular longitudinal bypass passage defined between the tubular inner mandrel and the bypass tube.

12. The apparatus of claim 11, wherein the longitudinal passages of the tubular adapter, bypass tube, and tubular expansion cone mandrel are fluidically coupled.

13. The apparatus of claim 11, wherein the longitudinal passage of the tubular expansion cone mandrel is fluidically coupled to the radial pressure port of the tubular expansion cone mandrel.
14. The apparatus of claim 11, wherein the L-shaped bypass port of the tubular expansion cone mandrel is fluidically coupled to the annular longitudinal bypass passage, the radial bypass passages of the tubular inner mandrel, the L-shaped bypass ports of the tubular hydraulic slip body, and the radial bypass ports of the tubular outer sleeve.
15. An apparatus for radially expanding and plastically deforming a tubular member, comprising:
- a tubular support member defining a longitudinal passage;
 - a tubular outer sleeve coupled to the tubular support member defining a longitudinal passage and a plurality of radial bypass ports;
 - an hydraulic slip coupled to the tubular outer sleeve for controllably engaging the tubular member;
 - one or more packer cups coupled to the tubular outer sleeve for sealingly engaging the tubular member;
 - a tubular inner sleeve positioned within and movably coupled to the tubular outer sleeve defining a longitudinal passage, an annular longitudinal bypass passage, and one or more radial bypass passages; and
 - a tubular expansion cone coupled to the tubular inner sleeve defining a longitudinal passage having a throat passage for receiving a ball, an L-shaped bypass port, and a radial pressure port including an tapered outer expansion surface for radially expanding and plastically deforming the tubular member.
16. The apparatus of claim 15, wherein the longitudinal passages of the tubular outer sleeve and the tubular expansion cone are fluidically coupled.
17. The apparatus of claim 15, wherein the longitudinal passage of the tubular expansion cone is fluidically coupled to the radial pressure port of the tubular expansion cone.
18. The apparatus of claim 15, wherein the L-shaped bypass port of the tubular expansion cone is fluidically coupled to the annular longitudinal bypass passage and the radial bypass passages of the tubular inner sleeve, and the L-shaped bypass ports and the radial bypass ports of the tubular outer sleeve.

19. A method of radially expanding and plastically deforming a wellbore casing positioned within a borehole that traverses a subterranean formation, comprising:
- 5 positioning an outer tubular sleeve and an inner tubular sleeve comprising an expansion cone within the borehole, wherein the inner tubular sleeve is movably coupled to and at least partially housed within the outer tubular sleeve;
- injecting a fluidic material into the inner and outer tubular sleeves;
- coupling the outer tubular sleeve to the wellbore casing; and
- 10 extending the inner tubular sleeve out of the outer tubular sleeve into the wellbore casing to radially expand and plastically deform a portion of the wellbore casing using the expansion cone.
20. The method of claim 19, wherein injecting a fluidic material into the inner and outer tubular sleeves comprises:
- injecting the fluidic material into an annular chamber above the expansion cone.
- 15 21. The method of claim 19, further comprising:
- conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve to a location above the expansion cone.
22. The method of claim 21, wherein conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve above the expansion cone
- 20 comprises:
- conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve through an annular passage and one or more radial passages to the location above the expansion cone.
23. The method of claim 19, further comprising:
- 25 depressuring the inner and outer tubular sleeves;
- decoupling the outer tubular sleeve and the wellbore casing; and
- collapsing the outer tubular sleeve onto the inner tubular sleeve.
24. The method of claim 23, further comprising:
- injecting a fluidic material into the inner and outer tubular sleeves;
- 30 coupling the outer tubular sleeve to the wellbore casing;
- extending the inner tubular sleeve out of the outer tubular sleeve into the wellbore casing to radially expand and plastically deform another portion of the wellbore casing.
25. The method of claim 24, wherein injecting a fluidic material into the inner and

outer tubular sleeves comprises:

injecting the fluidic material into an annular chamber above the expansion cone.

26. The method of claim 24, further comprising:

conveying fluidic materials within the borehole displaced by the extension of the

5

inner tubular sleeve to a location above the expansion cone.

27. The method of claim 26, wherein conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve above the expansion cone

comprises:

conveying fluidic materials within the borehole displaced by the extension of the

10

inner tubular sleeve through an annular passage and one or more radial passages to the location above the expansion cone.

28. An apparatus for radially expanding and plastically deforming a wellbore casing positioned within a borehole that traverses a subterranean formation, comprising:

means for positioning an outer tubular sleeve and an inner tubular sleeve

15

comprising an expansion cone within the borehole, wherein the inner tubular sleeve is movably coupled to and at least partially housed within the outer tubular sleeve;

means for injecting a fluidic material into the inner and outer tubular sleeves;

means for coupling the outer tubular sleeve to the wellbore casing; and

20

means for extending the inner tubular sleeve out of the outer tubular sleeve into the wellbore casing to radially expand and plastically deform a portion of the wellbore casing using the expansion cone.

29. The apparatus of claim 28, wherein means for injecting a fluidic material into the inner and outer tubular sleeves comprises:

25

means for injecting the fluidic material into an annular chamber above the expansion cone.

30. The apparatus of claim 28, further comprising:

means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve to a location above the expansion cone.

30

31. The apparatus of claim 30, wherein means for conveying fluidic materials within the borehole displaced by the extension of the inner tubular sleeve above the expansion cone comprises:

means for conveying fluidic materials within the borehole displaced by the

extension of the inner tubular sleeve through an annular passage and
one or more radial passages to the location above the expansion cone.

32. The apparatus of claim 28, further comprising:

means for depressuring the inner and outer tubular sleeves;

5 means for decoupling the outer tubular sleeve and the wellbore casing; and

means for collapsing the outer tubular sleeve onto the inner tubular sleeve.

33. The apparatus of claim 32, further comprising:

means for injecting a fluidic material into the inner and outer tubular sleeves;

means for coupling the outer tubular sleeve to the wellbore casing;

10 means for extending the inner tubular sleeve out of the outer tubular sleeve into
the wellbore casing to radially expand and plastically deform another
portion of the wellbore casing.

34. The apparatus of claim 33, wherein means for injecting a fluidic material into the
inner and outer tubular sleeves comprises:

15 means for injecting the fluidic material into an annular chamber above the
expansion cone.

35. The apparatus of claim 33, further comprising:

means for conveying fluidic materials within the borehole displaced by the

extension of the inner tubular sleeve to a location above the expansion

20 cone.

36. The apparatus of claim 35, wherein means for conveying fluidic materials within
the borehole displaced by the extension of the inner tubular sleeve above the
expansion cone comprises:

means for conveying fluidic materials within the borehole displaced by the

25 extension of the inner tubular sleeve through an annular passage and
one or more radial passages to the location above the expansion cone.

33

Application No: GB0525768.8

Examiner: Dr Michael Gooch

Claims searched: 1-4

Date of search: 3 February 2006

Patents Act 1977: Search Report under Section 17

Documents considered to be relevant:

Category	Relevant to claims	Identity of document and passage or figure of particular relevance
A	-	GB 2408278 A (EVENTURE)

Categories:

X	Document indicating lack of novelty or inventive step	A	Document indicating technological background and/or state of the art
Y	Document indicating lack of inventive step if combined with one or more other documents of same category	P	Document published on or after the declared priority date but before the filing date of this invention
&	Member of the same patent family	E	Patent document published on or after, but with priority date earlier than, the filing date of this application

Field of Search:

Search of GB, EP, WO & US patent documents classified in the following areas of the UKC^x :

E1F

Worldwide search of patent documents classified in the following areas of the IPC

E21B

The following online and other databases have been used in the preparation of this search report

Online: EPODOC, WPI